



## INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

<b>(51) International Patent Classification <sup>6</sup> :</b> <b>C07D 495/04, A61K 31/435 // (C07D 495/04, 333:00, 221:00)</b>	<b>A1</b>	<b>(11) International Publication Number:</b> <b>WO 00/00493</b> <b>(43) International Publication Date:</b> 6 January 2000 (06.01.00)
<b>(21) International Application Number:</b> PCT/JP99/03379 <b>(22) International Filing Date:</b> 24 June 1999 (24.06.99)  <b>(30) Priority Data:</b> 10/181263                      26 June 1998 (26.06.98)                      JP 10/333004                      24 November 1998 (24.11.98)                      JP  <b>(71) Applicant (for all designated States except US):</b> TAKEDA CHEMICAL INDUSTRIES, LTD. [JP/JP]; 1-1, Doshomachi 4-chome, Chuo-ku, Osaka-shi, Osaka 541-0045 (JP).  <b>(72) Inventors; and</b> <b>(75) Inventors/Applicants (for US only):</b> FURUYA, Shuichi [JP/JP]; 7-9-603, Kasuga 1-chome, Tsukuba-shi, Ibaraki 305-0821 (JP). CHOH, Nobuo [JP/JP]; 7-9-502, Kasuga 1-chome, Tsukuba-shi, Ibaraki 305-0821 (JP). SUZUKI, Nobuhiro [JP/JP]; 1077-50, Oaza-yatabe, Tsukuba-shi, Ibaraki 305-0861 (JP). IMADA, Takashi [JP/JP]; 9-15-205, Kasuga 2-chome, Tsukuba-shi, Ibaraki 305-0821 (JP).  <b>(74) Agents:</b> ASAHINA, Tadao et al.; Osaka Plant of Takeda Chemical Industries, Ltd., 17-85, Jusohonmachi 2-chome, Yodogawa-ku, Osaka-shi, Osaka 532-0024 (JP).	<b>(81) Designated States:</b> AE, AL, AM, AU, AZ, BA, BB, BG, BR, BY, CA, CN, CU, CZ, EE, GD, GE, HR, HU, ID, IL, IN, IS, JP, KG, KR, KZ, LC, LK, LR, LT, LV, MD, MG, MK, MN, MX, NO, NZ, PL, RO, RU, SG, SI, SK, SL, TJ, TM, TR, TT, UA, US, UZ, VN, YU, ZA, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).  <b>Published</b> <i>With international search report.</i> <i>Before the expiration of the time limit for amending the</i> <i>claims and to be republished in the event of the receipt of</i> <i>amendments.</i>	
<b>(54) Title:</b> THIENOPYRIDINE COMPOUNDS, THEIR PRODUCTION AND USE		
<b>(57) Abstract</b> <p>The compound of the present invention possesses excellent gonadotropin-releasing hormone antagonizing activity, and is useful for preventing or treating sex hormone-dependent diseases, e.g., sex hormone-dependent cancers (e.g., prostatic cancer, uterine cancer, breast cancer, pituitary tumor), prostatic hypertrophy, hysteromyoma, endometriosis, precocious puberty, amenorrhea syndrome, multifocal ovary syndrome, pimples etc., or as a pregnancy regulator (e.g., contraceptive), infertility remedy or menstruation regulator.</p>		

**FOR THE PURPOSES OF INFORMATION ONLY**

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece	ML	Mali	TR	Turkey
BG	Bulgaria	HU	Hungary	MN	Mongolia	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MR	Mauritania	UA	Ukraine
BR	Brazil	IL	Israel	MW	Malawi	UG	Uganda
BY	Belarus	IS	Iceland	MX	Mexico	US	United States of America
CA	Canada	IT	Italy	NE	Niger	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NL	Netherlands	VN	Viet Nam
CG	Congo	KE	Kenya	NO	Norway	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NZ	New Zealand	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	PL	Poland		
CM	Cameroon	KR	Republic of Korea	PT	Portugal		
CN	China	KZ	Kazakhstan	RO	Romania		
CU	Cuba	LC	Saint Lucia	RU	Russian Federation		
CZ	Czech Republic	LI	Liechtenstein	SD	Sudan		
DE	Germany	LK	Sri Lanka	SE	Sweden		
DK	Denmark	LR	Liberia	SG	Singapore		
EE	Estonia						

## DESCRIPTION

## Thienopyridine Compounds, Their Production and Use

## TECHNICAL FIELD

5           The present invention relates to thieno[2,3-b]pyridine derivatives exhibiting gonadotropin releasing hormone (GnRH) antagonizing activity, their production and use.

## BACKGROUND ART

10           The secretion of hypophyseal anterior lobe hormone is regulated by the peripheral hormone secreted by each target organ and the secretion-promoting or secretion-suppressing hormone secreted by the hypothalamus, which is the center superior to the hypophyseal anterior lobe, and this group of  
15 hormones hereinafter generically referred to as hypothalamic hormone in this specification. To date, nine hypothalamic hormones have been identified, for example, thyroid-stimulating hormone-releasing hormone (TRH), and  
20 luteinizing hormone releasing hormone [GnRH, also known as gonadotropin releasing hormone (LH-RH)], etc. It is conjectured that these hypothalamic hormones exhibit their hormone actions etc. via receptors assumed to be present in the hypophyseal anterior lobe, and analyses of receptor genes specific to these hormones, including humans, are ongoing.  
25 Antagonists or agonists that act specifically and selectively on these receptors would therefore regulate the action of hypothalamic hormones and hence regulate the secretion of hypophyseal anterior lobe hormone. As a result, such antagonists or agonists are expected to prevent or treat  
30 diseases depending on these hypophyseal anterior lobe hormone.

          Known compounds possessing GnRH-antagonizing activity include GnRH-derived linear peptides (USP 5,140,009 and USP 5,171,835), a cyclic hexapeptide derivative (JP-A-61-  
35 191698), a bicyclic peptide derivative [Journal of Medicinal

Chemistry, Vol. 36, pp. 3265-3273 (1993)], and so forth. Non-peptide compounds possessing GnRH-antagonizing activity include compounds described in WO 95/28405, WO 97/14697, WO 97/14682, WO 97/41126 and so forth.

5           Peptide compounds pose a large number of problems to be resolved with respect to oral absorbability, dosage form, dose volume, drug stability, sustained action, metabolic stability etc. There is strong demand for an oral GnRH antagonist, especially one based on a non-peptide compound,  
10   that has excellent therapeutic effect on hormone-dependent cancers, e.g., prostatic cancer, endometriosis, precocious puberty etc., and that does not show transient hypophysial-gonadotropic action (acute action).

#### 15   BRIEF DESCRIPTION OF DRAWINGS

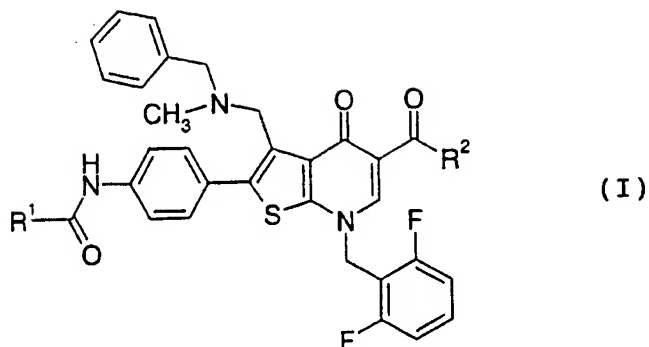
          Fig. 1 is a diagrammatic representation of the ameliorating effect of suppression of plasma LH concentrations in castrated monkeys after oral administration of the compound of the following Example 1-2,  
20   in which ...■... represents control (1) (vehicle), ...◆... represents control (2) (vehicle), ...□... represents control (3) (vehicle), -△- represents compound (1) [the test animal administered the compound of Ex. No. 1-2] and -▲- represents compound (2) [the test animal administered the  
25   compound of Ex. No. 1-2].

#### DISCLOSURE OF INVENTION

          The present inventors produced various thienopyridine derivatives, investigated their actions, and found that some  
30   compounds possess excellent GnRH-antagonizing activity. The inventors have conducted further investigation based on this finding, and developed the present invention.

          Accordingly, the present invention relates to:

[1] a compound of the formula:



wherein R<sup>1</sup> represents a C<sub>1-7</sub> alkyl group which may be substituted, a C<sub>3-7</sub> cycloalkyl group which may be substituted, a C<sub>1-6</sub> alkoxyamino group which may be substituted or a hydroxyamino group which may be substituted; and

R<sup>2</sup> represents a C<sub>1-7</sub> alkyl group which may be substituted or  
10 a phenyl group which may be substituted;

when R<sup>1</sup> is an unsubstituted C<sub>1-7</sub> alkyl group, then R<sup>2</sup> is a substituted C<sub>1-7</sub> alkyl group or a substituted phenyl group, or a salt thereof [hereinafter sometimes referred to briefly as compound (I)];

15 [2] a compound of the above (1) or a salt thereof,  
wherein R<sup>1</sup> is (1) a C<sub>1-7</sub> alkyl group which may be substituted  
by 1 to 5 substituents selected from the group consisting of  
(i) hydroxy, (ii) C<sub>1-7</sub> acyloxy, (iii) amino which may be  
substituted by 1 or 2 substituents selected from the group  
20 consisting of C<sub>1-6</sub> alkoxy-carbonyl, benzyloxycarbonyl, C<sub>1-3</sub>  
acyl, C<sub>1-3</sub> alkylsulfonyl and C<sub>1-3</sub> alkyl, (iv) C<sub>1-10</sub> alkoxy  
which may be substituted by 1 to 3 substituents selected from  
the group consisting of C<sub>3-7</sub> cycloalkyloxy-carbonyl and C<sub>1-3</sub>  
alkoxy and (v) C<sub>1-6</sub> alkoxy-carbonyl,

25 (2) a C<sub>3-7</sub> cycloalkyl group which may be substituted by 1 to

3 substituents selected from the group consisting of (i) hydroxy, (ii) C<sub>1-7</sub> acyloxy, (iii) amino which may be substituted by 1 or 2 substituents selected from the group consisting of C<sub>1-6</sub> alkoxy-carbonyl, benzyloxycarbonyl, C<sub>1-3</sub> acyl, C<sub>1-3</sub> alkylsulfonyl and C<sub>1-3</sub> alkyl, (iv) C<sub>1-10</sub> alkoxy which may be substituted by 1 to 3 substituents selected from the group consisting of C<sub>3-7</sub> cycloalkyloxy-carbonyl and C<sub>1-3</sub> alkoxy and (v) C<sub>1-6</sub> alkoxy-carbonyl,

(3) a C<sub>1-6</sub> alkoxyamino group which may be substituted by 1 to 5 substituents selected from the group consisting of (i) hydroxy, (ii) C<sub>1-7</sub> acyloxy, (iii) amino which may be substituted by 1 or 2 substituents selected from the group consisting of C<sub>1-6</sub> alkoxy-carbonyl, benzyloxycarbonyl, C<sub>1-3</sub> acyl, C<sub>1-3</sub> alkylsulfonyl and C<sub>1-3</sub> alkyl, (iv) C<sub>1-10</sub> alkoxy which may be substituted by 1 to 3 substituents selected from the group consisting of C<sub>3-7</sub> cycloalkyloxy-carbonyl and C<sub>1-3</sub> alkoxy and (v) C<sub>1-6</sub> alkoxy-carbonyl, or

(4) a hydroxyamino group which may be substituted by 1 or 2 substituents selected from the group consisting of (i) C<sub>1-7</sub> acyloxy, (ii) amino which may be substituted by 1 or 2 substituents selected from the group consisting of C<sub>1-6</sub> alkoxy-carbonyl, benzyloxycarbonyl, C<sub>1-3</sub> acyl, C<sub>1-3</sub> alkylsulfonyl and C<sub>1-3</sub> alkyl, (iii) C<sub>1-10</sub> alkoxy which may be substituted by 1 to 3 substituents selected from the group consisting of C<sub>3-7</sub> cycloalkyloxy-carbonyl and C<sub>1-3</sub> alkoxy and (iv) C<sub>1-6</sub> alkyl; and

R<sup>2</sup> is (1) a C<sub>1-7</sub> alkyl group which may be substituted by 1 to 5 substituents selected from the group consisting of (i) hydroxy, (ii) C<sub>1-7</sub> acyloxy, (iii) amino which may be substituted by 1 or 2 substituents selected from the group consisting of C<sub>1-6</sub> alkoxy-carbonyl, benzyloxycarbonyl, C<sub>1-3</sub>

acyl, C<sub>1-3</sub> alkylsulfonyl and C<sub>1-3</sub> alkyl, (iv) C<sub>1-10</sub> alkoxy which may be substituted by 1 to 3 substituents selected from the group consisting of C<sub>3-7</sub> cycloalkyloxy-carbonyl and C<sub>1-3</sub> alkoxy and (v) C<sub>1-6</sub> alkoxy-carbonyl, or

- 5 (2) a phenyl group which may be substituted by 1 to 5 substituents selected from the group consisting of halogen, C<sub>1-3</sub> alkyl and C<sub>1-3</sub> alkoxy;

[3] a compound of the above (1) or a salt thereof, wherein R<sup>1</sup> is a C<sub>1-7</sub> alkyl group which may be substituted or  
10 a C<sub>3-7</sub> cycloalkyl group which may be substituted;

[4] a compound of the above (1) or a salt thereof, wherein R<sup>1</sup> is a substituted branched C<sub>3-7</sub> alkyl group or a substituted C<sub>3-7</sub> cycloalkyl group;

[5] a compound of the above (1) or a salt thereof, wherein R<sup>1</sup> is a C<sub>1-7</sub> alkyl group substituted by hydroxy or  
15 a C<sub>3-7</sub> cycloalkyl group substituted by hydroxy;

[6] a compound of the above (1) or a salt thereof, wherein R<sup>1</sup> is a substituted C<sub>3-7</sub> cycloalkyl group;

[7] a compound of the above (1) or a salt thereof, wherein R<sup>1</sup> is a cyclopropyl group which may be substituted  
20 by hydroxy;

[8] a compound of the above (1) or a salt thereof, wherein R<sup>2</sup> is a branched C<sub>3-7</sub> alkyl group which may be substituted;

25 [9] a compound of the above (1) or a salt thereof, wherein R<sup>2</sup> is a phenyl group which may be substituted;

[10] a compound of the above (1) or a salt thereof, wherein R<sup>2</sup> is a phenyl group;

[11] a compound of the above (1) or a salt thereof, wherein R<sup>1</sup> is a C<sub>3-7</sub> cycloalkyl group and R<sup>2</sup> is a C<sub>1-6</sub> alkyl  
30 group;

[12] a compound of the above (1) or a salt thereof, wherein  $R^1$  is (1) a  $C_{1-4}$  alkyl group substituted by 1 or 2 hydroxy, (2) a  $C_{3-7}$  cycloalkyl group substituted by hydroxy, or (3) a  $C_{1-3}$  alkoxyamino group; and

5  $R^2$  is an isopropyl group or a phenyl group;

[13] a compound of the above (1) or a salt thereof, wherein  $R^1$  is (1) a  $C_{1-7}$  alkyl group which may be substituted by 1 or 2 substituents selected from the group consisting of hydroxy,  $C_{1-3}$  alkyl-carbonyloxy, amino,

10 benzyloxycarbonylamino,  $C_{1-3}$  alkoxy,  $C_{1-3}$  alkoxy- $C_{1-3}$  alkoxy and  $C_{1-3}$  alkoxy-carbonyl, (2) a  $C_{3-7}$  cycloalkyl group which may be substituted by a hydroxy or a  $C_{1-3}$  alkyl-carbonyloxy, or (3) a  $C_{1-3}$  alkoxyamino group; and

$R^2$  is (1) an isopropyl group which may be substituted by a hydroxy or (2) a phenyl group;

15 [14] 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-(4-cyclopropanecarbonylamino)phenyl)-4-oxothieno[2,3-b]pyridine or a salt thereof;

20 [15] 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-[4-(3-hydroxy-2-methylpropionylamino)phenyl]-4-oxothieno[2,3-b]pyridine or a salt thereof;

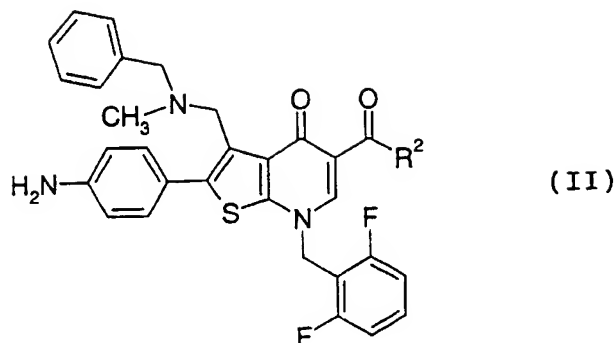
25 [16] 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-[4-[(1-hydroxycyclopropyl)carbonylamino]phenyl]-4-oxothieno[2,3-b]pyridine or a salt thereof;

30 [17] 3-(N-benzyl-N-methylaminomethyl)-5-benzoyl-7-(2,6-difluorobenzyl)-4,7-dihydro-2-[4-[(1-hydroxycyclopropyl)carbonylamino]phenyl]-4-oxothieno[2,3-b]pyridine or a salt thereof;

[18] a process for producing a compound of the above [1] or a salt thereof, which comprises reacting a compound of the



formula:



5 wherein  $R^2$  represents a  $C_{1-7}$  alkyl group which may be substituted or a phenyl group which may be substituted, or a salt thereof [hereinafter sometimes referred to briefly as compound (II)], with

i) a compound of the formula:



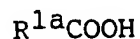
wherein  $R^{1a}$  represents a  $C_{1-7}$  alkyl group which may be substituted or a  $C_{3-7}$  cycloalkyl group which may be substituted, or a salt thereof or a reactive derivative thereof; or

15 ii) carbonyldiimidazole, phosgene or a chloroformate, followed by reacting with a compound of the formula:



wherein  $R^{1b}$  represents a  $C_{1-6}$  alkoxyamino group which may be substituted or a hydroxyamino group which may be substituted, or a salt thereof;

20 [19] a process for producing a compound of the above [3] or a salt thereof, which comprises reacting compound (II) with a compound of the formula:



25 wherein  $R^{1a}$  represents a  $C_{1-7}$  alkyl group which may be substituted or a  $C_{3-7}$  cycloalkyl group which may be

substituted, or a salt thereof or a reactive derivative thereof;

[20] a pharmaceutical composition which comprises a compound of the above (1) or a salt thereof;

5 [21] a pharmaceutical composition of the above (20) which is for antagonizing gonadotropin-releasing hormone;

[22] a pharmaceutical composition of the above (21) which is for preventing or treating a sex hormone dependent disease;

10 [23] a method for antagonizing gonadotropin-releasing hormone in a mammal in need thereof which comprises administering to said mammal an effective amount of a compound of the above (1) or a salt thereof with a pharmaceutically acceptable excipient, carrier or diluent;

15 [24] use of a compound of the above (1) or a salt thereof for manufacturing a pharmaceutical composition for antagonizing gonadotropin-releasing hormone, and so forth.

Each symbol in the above formulae is hereinafter described in more detail.

20 The "C<sub>1-7</sub> alkyl group" of the "C<sub>1-7</sub> alkyl group which may be substituted" for R<sup>1</sup> includes, for example, a straight-chain C<sub>1-7</sub> alkyl group such as methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl, etc.; a branched C<sub>3-7</sub> alkyl group such as isopropyl, isobutyl, sec-butyl, tert-butyl, isopentyl, neopentyl, etc., and so forth. Among others, preferred is a branched C<sub>3-7</sub> alkyl group. More preferred is isopropyl.

30 The "substituents" of the "C<sub>1-7</sub> alkyl group which may be substituted" for R<sup>1</sup> include, for example, (i) hydroxy, (ii) C<sub>1-7</sub> acyloxy (e.g., C<sub>1-6</sub> alkyl-carboxyloxy such as acetoxy, propionyloxy, etc.; benzyloxy etc.), (iii) amino which may be substituted by 1 or 2 substituents selected from the group

consisting of C<sub>1-6</sub> alkoxy-carbonyl (e.g., methoxycarbonyl, ethoxycarbonyl, tert-butoxycarbonyl, etc.), benzyloxycarbonyl, C<sub>1-3</sub> acyl (e.g., C<sub>1-2</sub> alkyl-carbonyl such as acetyl, propionyl, etc.), C<sub>1-3</sub> alkylsulfonyl (e.g., methanesulfonyl etc.) and C<sub>1-3</sub> alkyl (e.g., methyl, ethyl, etc.), etc. [e.g.; amino, methoxycarbonylamino, ethoxycarbonylamino, tert-butoxycarbonylbenzyloxycarbonylamino, acetylamino, methanesulfonylamino, methylamino, dimethylamino, etc.), (iv) C<sub>1-10</sub> (preferably C<sub>1-4</sub>) alkoxy which may be substituted by 1 to 3 substituents selected from the group consisting of C<sub>3-7</sub> cycloalkyloxycarbonyl (e.g., cyclohexyloxycarbonyloxy, etc.) and C<sub>1-3</sub> alkoxy (e.g., methoxy, ethoxy, etc.) [e.g.; methoxy, ethoxy, propoxy, tert-butoxy, cyclohexyloxycarbonyloxy-1-ethoxy, methoxymethoxy, ethoxymethoxy, etc.], (v) C<sub>1-6</sub> alkoxy-carbonyl (e.g., methoxycarbonyl, ethoxycarbonyl, propoxycarbonyl, etc.), and so forth. Among others, preferred is hydroxy.

The "C<sub>1-7</sub> alkyl group" may have 1 to 5, preferably 1 to 3 substituents as mentioned above at possible positions and, when the number of substituents is two or more, those substituents may be the same as or different from one another.

The "C<sub>3-7</sub> cycloalkyl group" of the "C<sub>3-7</sub> cycloalkyl group which may be substituted" for R<sup>1</sup> includes, for example, cyclopropyl, cyclobutyl, cyclopentyl, cyclohexyl, cycloheptyl, etc. Among others, preferred is cyclopropyl.

The "substituents" of the "C<sub>3-7</sub> cycloalkyl group which may be substituted" for R<sup>1</sup> are the same as those mentioned above for the "substituents" of the "C<sub>1-7</sub> alkyl group which may be substituted" for R<sup>1</sup>. The number of substituents is 1 to 3. When the number of substituents is two or more, those

substituents may be the same as or different from one another.

The "C<sub>1-6</sub> alkoxyamino group" of the "C<sub>1-6</sub> alkoxyamino group which may be substituted" for R<sup>1</sup> includes, for example, mono- or di-C<sub>1-6</sub> alkoxyamino (e.g., methoxyamino, ethoxyamino, dimethoxyamino, diethoxyamino, ethoxymethoxyamino, etc.), etc. Among others, preferred is mono-C<sub>1-3</sub> alkoxyamino (e.g., methoxyamino, etc.).

The "substituents" of the "C<sub>1-6</sub> alkoxyamino group which may be substituted" for R<sup>1</sup> and their number are the same as those mentioned above for the "substituents" of the "C<sub>1-7</sub> alkyl group which may be substituted" for R<sup>1</sup>. When the number of substituents is two or more, those substituents may be the same as or different from one another. The "C<sub>1-6</sub> alkoxy" or the "nitrogen atom of an amino group" of the C<sub>1-6</sub> alkoxyamino group may be substituted by the above "substituents".

Such "C<sub>1-6</sub> alkoxyamino group which may be substituted" is exemplified by methoxyamino, N-methyl-N-methoxyamino, N-ethyl-N-methoxyamino, ethoxyamino, dimethoxyamino, diethoxyamino, ethoxymethoxyamino, etc. Preferred is C<sub>1-3</sub> alkoxyamino, N-C<sub>1-3</sub> alkyl-N-C<sub>1-3</sub> alkoxyamino, etc.

The "substituents" of the "hydroxyamino group which may be substituted" for R<sup>1</sup> may be located on the "hydroxy group" of the hydroxyamino group or the "nitrogen atom of an amino group" of the hydroxyamino group. Such "substituents" on the "hydroxy group" include, for example, (i) C<sub>1-7</sub> acyloxy (e.g., C<sub>1-6</sub> alkyl-carbonyloxy such as acetoxy, propionyloxy, etc.; benzoyloxy etc.), (ii) amino which may be substituted by 1 or 2 substituents selected from the group consisting of C<sub>1-6</sub> alkoxy-carbonyl (e.g., methoxycarbonyl, ethoxycarbonyl, tert-butoxycarbonyl, etc.), benzyloxycarbonyl, C<sub>1-3</sub> acyl (e.g., C<sub>1-2</sub> alkyl-carbonyl such

as acetyl, propionyl, etc.), C<sub>1-3</sub> alkylsulfonyl (e.g., methanesulfonyl etc.) and C<sub>1-3</sub> alkyl (e.g., methyl, ethyl, etc.), etc. [e.g.; amino, methoxycarbonylamino, ethoxycarbonylamino, tert-butoxycarbonylbenzyloxycarbonylamino, acetylamino, methanesulfonylamino, methylamino, dimethylamino, etc.], (iii) C<sub>1-10</sub> (preferably C<sub>1-4</sub>) alkoxy which may be substituted by 1 to 3 substituents selected from the group consisting of C<sub>3-7</sub> cycloalkyloxycarbonyl (e.g., cyclohexyloxycarbonyloxy, etc.) and C<sub>1-3</sub> alkoxy (e.g., methoxy, ethoxy, etc.) [e.g.; methoxy, ethoxy, propoxy, tert-butoxy, cyclohexyloxycarbonyloxy-1-ethoxy, methoxymethoxy, ethoxymethoxy, etc.], and so forth. The number of substituents is 1 to 5, preferably 1 to 3. When the number of substituents is two or more, those substituents may be the same as or different from one another. Such "substituents" on the "nitrogen atom of the amino group" include, for example, (1) each group as described in the above (i) to (iii) and (2) C<sub>1-6</sub> alkyl (e.g., methyl, ethyl, propyl, isopropyl, butyl, isobutyl, sec-butyl, tert-butyl, pentyl, isopentyl, neopentyl, hexyl, etc. The number of substituents is 1 to 5, preferably 1 to 3. When the number of substituents is two or more, those substituents may be the same as or different from one another.

Preferable examples of the "hydroxyamino group which may be substituted" include N-C<sub>1-6</sub> alkyl-N-hydroxyamino (e.g., N-methyl-N-hydroxyamino, N-ethyl-N-hydroxyamino, etc.) and so forth. More preferred is N-C<sub>1-3</sub> alkyl-N-hydroxyamino, etc.

30

The "C<sub>1-7</sub> alkyl group" of the "C<sub>1-7</sub> alkyl group which may be substituted" for R<sup>2</sup> includes, for example, a straight-chain or branched C<sub>1-7</sub> alkyl group such as methyl,

ethyl, propyl, isopropyl, butyl, isobutyl, sec-butyl, tert-butyl, pentyl, isopentyl, neopentyl, hexyl, heptyl, etc. Among others, preferred is C<sub>1-3</sub> alkyl (e.g., methyl, ethyl, propyl, isopropyl, etc. More preferred is isopropyl.

5       The "substituents" of the "C<sub>1-7</sub> alkyl group which may be substituted" for R<sup>2</sup> and their number are the same as those mentioned above for the "substituents" of the "C<sub>1-7</sub> alkyl group which may be substituted" for R<sup>1</sup>. When the number of substituents is two or more, those substituents may be the same as or different from one another.

10       The "substituents" of the "phenyl group which may be substituted" for R<sup>2</sup> includes, for example, halogen (e.g., fluoro, chloro, bromo, iodo, etc.), C<sub>1-3</sub> alkyl (e.g., methyl, ethyl, propyl, isopropyl, etc.), C<sub>1-3</sub> alkoxy (e.g., methoxy, ethoxy, propoxy, isopropoxy, etc.), etc. Among others, preferred is halogen, more preferred is fluoro.

15       The "phenyl group" may have 1 to 5, preferably 1 to 3 substituents as mentioned above at possible positions and, when the number of substituents is two or more, those substituents may be the same as or different from one another.

20       R<sup>1</sup> is preferably a substituted branched C<sub>3-7</sub> alkyl group or a substituted C<sub>3-7</sub> cycloalkyl group, more preferably a C<sub>1-7</sub> alkyl group substituted by hydroxy or a C<sub>3-7</sub> cycloalkyl group substituted by hydroxy. Among others, preferred is a substituted C<sub>3-7</sub> cycloalkyl group. Also, a C<sub>1-3</sub> alkyl group which may be substituted by hydroxy, a C<sub>3-7</sub> cycloalkyl group which may be substituted by a hydroxy, mono-C<sub>1-3</sub> alkoxyamino, N-C<sub>1-3</sub> alkyl-N-hydroxyamino, hydroxyamino, is preferred.

25       Especially preferably R<sup>1</sup> is (i) cyclopropyl which may be substituted by a hydroxy or (ii) methoxyamino, etc. Most preferred is cyclopropyl which may be substituted by a hydroxy

group.

$R^2$  is preferably a  $C_{1-7}$  alkyl group which may be substituted. More preferred is a  $C_{1-3}$  alkyl group which may be substituted by a hydroxy group. Especially preferred is isopropyl. Phenyl is also preferred.

Preferable examples of compound (I) include a compound wherein,  $R^1$  is a  $C_{1-3}$  alkyl group which may be substituted by a hydroxy group, a  $C_{3-7}$  cycloalkyl group which may be substituted by a hydroxy group or a mono- $C_{1-3}$  alkoxyamino group; and

$R^2$  is a  $C_{1-3}$  alkyl group, or a salt thereof.

More preferred is a compound wherein  $R^1$  is (1) a  $C_{1-4}$  alkyl group substituted by 1 or 2 hydroxy, (2) a  $C_{3-7}$  cycloalkyl group substituted by hydroxy, or (3) a  $C_{1-3}$  alkoxyamino group; and

$R^2$  is an isopropyl group or a phenyl group, or a salt thereof.

A compound wherein  $R^1$  is (1) a  $C_{1-7}$  alkyl group which may be substituted by 1 or 2 substituents selected from the group consisting of hydroxy,  $C_{1-3}$  alkyl-carbonyloxy, amino, benzyloxycarbonylamino,  $C_{1-3}$  alkoxy,  $C_{1-3}$  alkoxy- $C_{1-3}$  alkoxy and  $C_{1-3}$  alkoxy-carbonyl, (2) a  $C_{3-7}$  cycloalkyl group which may be substituted by a hydroxy group or a  $C_{1-3}$  alkyl-carbonyloxy, or (3) a  $C_{1-3}$  alkoxyamino group; and

$R^2$  is (1) an isopropyl group which may be substituted by a hydroxy group or (2) a phenyl group, or salt thereof is also preferred.

As compound (I), concretely mentioned are

3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-(4-

cyclopropanecarbonylamino)phenyl]-4-oxothieno[2,3-b]pyridine or a salt thereof,

5 5-benzoyl-3-(N-benzyl-N-methylaminomethyl)-7-(2,6-difluorobenzyl)-4,7-dihydro-4-oxo-2-[4-(3-hydroxy-2-methylpropionylamino)phenyl]thieno[2,3-b]pyridine,

5-(4-fluorobenzoyl)-3-(N-benzyl-N-methylaminomethyl)-7-(2,6-difluorobenzyl)-4,7-dihydro-4-oxo-2-(4-cyclopropanecarbonylamino)phenyl]thieno[2,3-b]pyridine,

10 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-[4-(3-hydroxy-2-methylpropionylamino)phenyl]-4-oxothieno[2,3-b]pyridine,

3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-(4-N'-methoxyureidophenyl)-4-oxothieno[2,3-b]pyridine,

15 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-[4-[(1-hydroxycyclopropyl)carbonylamino]phenyl]-4-oxothieno[2,3-b]pyridine,

20 (R)-4,7-dihydro-2-[4-(3-hydroxy-2-methylpropionylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-b]pyridine,

25 4,7-dihydro-2-[4-(2-hydroxy-2-methylpropionylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-b]pyridine,

30 4,7-dihydro-2-[4-(3-hydroxy-3-methylbutyrylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-b]pyridine,

(R)-4,7-dihydro-2-[4-(2,3-dihydroxypropionylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-b]pyridine,

35



3-(N-benzyl-N-methylaminomethyl)-5-benzoyl-7-(2,6-difluorobenzyl)-4,7-dihydro-2-[4-[(1-hydroxycyclopropyl)carbonylamino]phenyl]-4-oxothieno[2,3-b]pyridine, and salts thereof.

5

Compound (I) can be produced in any per se known manner, for example, according to the methods disclosed in WO 95/28405 or analogous methods thereto. Concretely mentioned are the following Production method 1 and Production method 2.

10

Production method 1:

Compound (I) is produced by reacting compound (II) with a compound of the formula:  $R^{1a}COOH$  wherein  $R^{1a}$  represents a  $C_{1-7}$  alkyl group which may be substituted or a  $C_{3-7}$  cycloalkyl group which may be substituted, or a salt thereof or a reactive derivative thereof [hereinafter sometimes referred to briefly as compound (III)].

15

The " $C_{1-7}$  alkyl group which may be substituted" and the " $C_{3-7}$  cycloalkyl group which may be substituted" for  $R^{1a}$  are the same as those mentioned above for the " $C_{1-7}$  alkyl group which may be substituted" and the " $C_{3-7}$  cycloalkyl group which may be substituted" for  $R^1$ , respectively.

20

The "reactive derivative" of the "compound of the formula:  $R^{1a}COOH$ , or a salt thereof or a reactive derivative thereof" includes, for example, a compound of the formula:  $R^{1a}COY$

25

wherein Y represents halogen and  $R^{1a}$  is same as defined above.

The amount of compound (III) to be reacted is about 1 to 3 mol, relative to one mol of compound (II).

30

This reaction is also carried out in the presence of a base. The "base" is exemplified by inorganic bases such as sodium carbonate, sodium hydrogen carbonate, potassium carbonate, potassium hydrogen carbonate, sodium hydroxide,

potassium hydroxide and thallium hydroxide, and organic bases such as triethylamine and pyridine, etc.

The amount of the "base" is about 1 to 10 mol, preferably about 2 to 5 mol, relative to one mol of compound (II).

5 In the case where a compound of the formula:  $R^{1a}COOH$  or a salt thereof is used, a condensing reagent which is generally used in peptide chemistry such as benzotriazol-1-yloxytripyrrolidinophosphonium hexafluorophosphate (PyBop) may be employed to form an amide bond.

10 This reaction is advantageously carried out in a solvent inert to the reaction. Examples of the solvent include ethers (e.g., ethyl ether, dioxane, dimethoxyethane, tetrahydrofuran, etc.), aromatic hydrocarbons (e.g., benzene, toluene, etc.), amides (e.g., dimethylformamide, 15 dimethylacetamide, etc.), halogenated hydrocarbons (e.g., chloroform, dichloromethane, etc.), and so forth.

The reaction temperature is usually about 0 to 150 °C, preferably room temperature (about 15 to 25 °C). The reaction time is usually about 1 to 12 hours.

20 Compound (II) can be produced in any *per se* known manner, for example, by the methods disclosed in WO 95/28405 or analogous methods thereto.

Compound (I) wherein  $R^1$  is a  $C_{1-6}$  alkoxyamino group which 25 may be substituted or a hydroxyamino group which may be substituted can also be produced in according to the method of the following Production method 2.

#### Production method 2:

30 Compound (I) is produced by reacting compound (II) with carbonyldiimidazole (N,N'-carbonyldiimidazole; CDI), phosgene (monomer, dimer or trimer) or a chloroformate, followed by reacting with a compound of the formula:  $R^{1b}H$  wherein  $R^{1b}$  represents a  $C_{1-6}$  alkoxyamino group which may be

substituted or a hydroxyamino group which may be substituted, or a salt thereof [hereinafter sometimes referred to briefly as compound (IV)].

5 The "chloroformate" includes, for example, a compound of the formula:  $\text{Cl-COOY'}$  wherein  $\text{Y'}$  represents a  $\text{C}_{1-6}$  alkyl group, such as chloroformate ethyl, etc.

The " $\text{C}_{1-6}$  alkoxyamino group which may be substituted" and the "hydroxyamino group which may be substituted" for  $\text{R}^{1b}$  are the same as those mentioned above for the " $\text{C}_{1-6}$  alkoxyamino group which may be substituted" and the  
10 "hydroxyamino group which may be substituted" for  $\text{R}^1$ , respectively.

In the reaction of compound (II) with carbonyldiimidazole, phosgene or chloroformates,  
15 carbonyldiimidazole, phosgene or chloroformates is used in amount of about 1 to 3 mol, relative to one mol of compound (II).

This reaction is advantageously carried out in a solvent inert to the reaction. Examples of the solvent include ethers  
20 (e.g., ethyl ether, dioxane, dimethoxyethane, tetrahydrofuran, etc.), aromatic hydrocarbons (e.g., benzene, toluene, etc.), amides (e.g., dimethylformamide, dimethylacetamide, etc.), halogenated hydrocarbons (e.g., chloroform, dichloromethane, etc.), and so forth.

25 The reaction temperature is usually about 0 to 150 °C, preferably room temperature (about 15 to 25 °C). The reaction time is usually about 1 to 36 hours.

This reaction is also carried out in the presence of a base. The "base" is exemplified by inorganic bases such as  
30 sodium carbonate, sodium hydrogen carbonate, potassium carbonate, potassium hydrogen carbonate, sodium hydroxide, potassium hydroxide and thallium hydroxide, and organic bases such as triethylamine and pyridine, etc.

The amount of the "base" is about 2 to 20 mol, preferably

about 5 to 12 mol, relative to one mol of compound (II).

The following reaction with compound (IV) can be carried out in the same condition of the above reaction of compound (II) with carbonyldiimidazole, phosgene or a chloroformate.

5 The amount of compound (IV) is about 2 to 20 mol, preferably about 5 to 10 mol, relative to one mol of compound (II).

The reaction temperature is usually about 0 to 150 °C, preferably room temperature (about 15 to 25 °C). The reaction time is usually about 1 to 6 hours.

10

Compound (I) of the present invention may be isolated and purified by ordinary means of separation such as recrystallization, distillation and chromatography, etc. When the compound of the formula (I) is obtained in free form,  
15 it can be converted to a salt by per se known methods or analogous thereto. When compound (I) is obtained in salt form, it can be converted to the free form or another salt by per se known methods or analogous thereto.

20

Salts of compound (I) are preferably physiologically acceptable acid addition salts. Such salts include, for example, salts with inorganic acids (e.g., hydrochloric acid, hydrobromic acid, nitric acid, sulfuric acid, phosphoric acid) and physiologically acceptable acid addition salts with  
25 organic acids (e.g., formic acid, acetic acid, trifluoroacetic acid, fumaric acid, oxalic acid, tartaric acid, maleic acid, citric acid, succinic acid, malic acid, methanesulfonic acid, benzenesulfonic acid, p-

toluenesulfonic acid). When compound (I) has an acidic  
30 group, it may form a physiologically acceptable salt with an inorganic base (e.g., alkali metals such as sodium, potassium, calcium and magnesium, alkaline earth metals, ammonia) or an organic base (e.g., trimethylamine, triethylamine, pyridine, picoline, ethanolamine,

35 diethanolamine, triethanolamine, dicyclohexylamine, N,N'-

dibenzylethylenediamine).

Compound (I) may be a hydrate or a non-hydrate. The hydrate is exemplified by monohydrate, sesquihydrate and dihydrate.

5        When compound (I) is obtained as a mixture (racemate) of optically active configurations, it can be resolved into the (R)- and (S)-forms by the conventional optical resolution techniques.

10        Compound (I) of the present invention (hereinafter also referred to as "compound of the present invention") possesses excellent GnRH-antagonizing activity and low toxicity. In addition, it is excellent in oral absorbability, action sustainability, stability and pharmacokinetics. Furthermore, it can be easily produced. The compound of the  
15        present invention can therefore be safely used in a mammal (e.g., human, monkey, bovine, horse, dog, cat, rabbit, rat, mouse) for the preventing and/or treating diseases depending on male or female hormones, diseases due to excess of these hormone, etc., by suppressing gonadotropin secretion by its  
20        GnRH receptor-antagonizing action to control blood sex hormone concentrations.

For example, the compound of the present invention is useful for preventing and/or treating sex hormone-dependent cancers (e.g., prostatic cancer, uterine cancer, breast  
25        cancer, pituitary tumor, etc.), prostatic hypertrophy, hysterymyoma, endometriosis, precocious puberty, amenorrhea, premenstrual syndrome, multilocular ovary syndrome, pimples etc. The compound of the present invention is also useful for the regulation of reproduction in males  
30        and females (e.g., pregnancy regulators, menstruation cycle regulators, etc.). The compound of the present invention also be used as a male or female contraceptive, or as a female ovulation inducer. Based on its rebound effect after withdrawal, the compound of the present invention can be used  
35        to treat infertility.

In addition, the compound of the present invention is useful for regulation of animal estrous, improvement of meat quality and promotion of animal growth in the field of animal husbandry. The compound of the present invention is also  
5 useful as a fish spawning promoter.

Although the compound of the present invention can be used alone, it is effective to use in combination with a steroidal or non-steroidal anti-androgen agent or anti-estrogen agent. The compound of the present invention can  
10 also be used to suppress the transient rise in blood testosterone concentration (flare phenomenon) observed in administration of a super-agonist such as Leuprorelin acetate. The compound of the present invention can be used in combination with a super-agonist such as leuprorelin  
15 acetate, gonadorelin, buserelin, triptorelin, goserelin, nafarelin, histrelin, deslorelin, meterelin, lecorelin, and so forth. Among others, preferred is leuprorelin acetate. The compound of the present invention also may be used with a chemotherapeutic agent for cancer. A preferred example of  
20 such combination is the compound of the present invention in combination with chemotherapeutic agents such as ifosfamide, UTF, adriamycin, peplomycin and cisplatin for prostatic cancer. For breast cancer, the compound of the present invention can be used with chemotherapeutic agents such as  
25 cyclophosphamide, 5-FU, UFT, methotrexate, adriamycin, mitomycin C and mitoxantrone.

When the compound of the present invention is used for preventing and/or treating (as a prophylactic and/or therapeutic agent for) the above-mentioned diseases or used  
30 in the field of animal husbandry or fishery, it can be administered orally or non-orally, as formulated with a pharmaceutically acceptable carrier, normally in the form of solid preparations such as tablets, capsules, granules and powders for oral administration, or in the form of  
35 intravenous, subcutaneous, intramuscular or other

injections, suppositories or sublingual tablets for non-oral administration. It may also be sublingually, subcutaneously, intramuscularly or otherwise administered in the form of sustained-release preparations of sublingual tablets, microcapsules etc. Depending on symptom severity; subject age, sex, weight and sensitivity; duration and intervals of administration; property, dispensing and kind of pharmaceutical preparation; kind of active ingredient etc., daily dose is not subject to limitation. For use in the treatment of the above-described sex hormone-dependent cancers (e.g., prostatic cancer, uterine cancer, breast cancer, pituitary tumor), prostatic hypertrophy, hysterosioma, endometriosis, precocious puberty etc., daily dose is normally about 0.01 to 30 mg, preferably about 0.02 to 10 mg, and more preferably 0.1 to 10 mg, per kg weight of mammal, normally in 1 to 4 divided dosages.

The above doses are applicable to the use of the compound of the present invention in the field of animal husbandry or fishery. Daily dose is about 0.01 to 30 mg, preferably about 0.1 to 10 mg, per kg weight of subject organism, normally in 1 to 3 divided dosages.

In the pharmaceutical composition of the present invention, the amount of compound (I) is 0.01 to 100 % by weight or so of the total weight of the composition.

Pharmaceutically acceptable carriers are various organic or inorganic carrier substances in common use as pharmaceutical materials, including excipients, lubricants, binders and disintegrants for solid preparations, and solvents, dissolution aids, suspending agents, isotonicizing agents, buffers and soothing agents for liquid preparations. Other pharmaceutical additives such as preservatives, antioxidants, coloring agents and sweetening agents may be used as necessary.

Preferable excipients include, for example, lactose,

sucrose, D-mannitol, starch, crystalline cellulose and light silicic anhydride. Preferable lubricants include, for example, magnesium stearate, calcium stearate, talc and colloidal silica. Preferable binders include, for example, crystalline cellulose, sucrose, D-mannitol, dextrin, hydroxypropyl cellulose, hydroxypropylmethyl cellulose and polyvinylpyrrolidone. Preferable disintegrants include, for example, starch, carboxymethyl cellulose, carboxymethyl cellulose calcium, crosslinked carmellose sodium and carboxymethyl starch sodium. Preferable solvents include, for example, water for injection, alcohol, propylene glycol, macrogol, sesame oil and corn oil. Preferable dissolution aids include, for example, polyethylene glycol, propylene glycol, D-mannitol, benzyl benzoate, ethanol, trisaminomethane, cholesterol, triethanolamine, sodium carbonate and sodium citrate. Preferable suspending agents include, for example, surfactants such as stearyltriethanolamine, sodium lauryl sulfate, laurylaminopropionic acid, lecithin, benzalkonium chloride, benzethonium chloride and monostearic glycerol; and hydrophilic polymers such as polyvinyl alcohol, polyvinylpyrrolidone, carboxymethyl cellulose sodium, methyl cellulose, hydroxymethyl cellulose, hydroxyethyl cellulose and hydroxypropyl cellulose. Preferable isotonizing agents include, for example, sodium chloride, glycerol and D-mannitol. Preferable buffers include, for example, buffer solutions of phosphates, acetates, carbonates, citrates etc. Preferable soothing agents include, for example, benzyl alcohol. Preferable preservatives include, for example, paraoxybenzoic acid esters, chlorobutanol, benzyl alcohol, phenethyl alcohol, dehydroacetic acid and sorbic acid. Preferable antioxidants include, for example, sulfites and ascorbic acid.

By adding suspending agents, dissolution aids, stabilizers, isotonizing agents, preservatives, and so



forth, the compound of the present invention can be prepared as an intravenous, subcutaneous or intramuscular injection by a commonly known method. In such cases, the compound of the present invention can be freeze-dried as necessary by a commonly known method. In administration to humans, for example, the compound of the present invention can be safely administered orally or non-orally as such or as a pharmaceutical composition prepared by mixing it with a pharmacologically acceptable carrier, excipient and diluent selected as appropriate.

Such pharmaceutical compositions include oral preparations (e.g., powders, granules, capsules, tablets), injections, drip infusions, external preparations (e.g., nasal preparations, transdermal preparations) and suppositories (e.g., rectal suppositories, vaginal suppositories).

These preparations can be produced by commonly known methods in common use for pharmaceutical making processes.

An injection can be produced by, for example, preparing the compound of the present invention as an aqueous injection along with a dispersing agent (e.g., Tween 80, produced by Atlas Powder Company, USA, HCO 60, produced by Nikko Chemicals Co., Ltd., polyethylene glycol, carboxymethyl cellulose, sodium alginate), a preservative (e.g., methyl paraben, propyl paraben, benzyl alcohol), an isotonizing agent (e.g., sodium chloride, mannitol, sorbitol, glucose) and other additives, or as an oily injection in solution, suspension or emulsion in a vegetable oil such as olive oil, sesame oil, cottonseed oil or corn oil, propylene glycol or the like.

An oral preparation can be produced by shaping the compound of the present invention by a commonly known method after addition of an excipient (e.g., lactose, sucrose, starch), a disintegrant (e.g., starch, calcium carbonate), a binder (e.g., starch, gum arabic, carboxymethyl cellulose, polyvinylpyrrolidone, hydroxypropyl cellulose), a lubricant

(e.g., talc, magnesium stearate, polyethylene glycol 6000) and other additives, and, where necessary, coating the shaped product for the purpose of taste masking, enteric dissolution or sustained release by a commonly known method. Coating agents for this purpose include, for example, hydroxypropylmethyl cellulose, ethyl cellulose, hydroxymethyl cellulose, hydroxypropyl cellulose, polyoxyethylene glycol, Tween 80, Prulonic F68, cellulose acetate phthalate, hydroxypropylmethyl cellulose phthalate, hydroxymethyl cellulose acetate succinate, Eudragit (produced by Rohm Company, Germany; methacrylic acid/acrylic acid copolymer) and dyes (e.g., iron oxide, titanium dioxide). For an enteric preparation, an intermediate phase may be provided between the enteric phase and the drug-containing phase for the purpose of separation of the two phases by a commonly known method.

An external preparation can be produced by compounding the compound of the present invention as a solid, semi-solid or liquid composition by a commonly known method. Such a solid composition is produced by, for example, powdering the compound of the present invention as such or in mixture with an excipient (e.g., glycol, mannitol, starch, microcrystalline cellulose), a thickening agent (e.g., natural rubber, cellulose derivative, acrylic acid polymer) and other additives. Such a liquid composition is produced by preparing the compound of the present invention as an oily or aqueous suspension in almost the same manner as with the injection. The semi-solid composition is preferably an aqueous or oily gel, or an ointment. All these compositions may contain pH regulators (e.g., carbonic acid, phosphoric acid, citric acid, hydrochloric acid, sodium hydroxide), preservatives (e.g., paraoxybenzoic acid esters, chlorobutanol, benzalkonium chloride) and other additives.

A suppository is produced by preparing the compound of the present invention as an oily or aqueous solid, semi-solid

or liquid composition by a commonly known method. Useful oily bases for such compositions include glycerides of higher fatty acids (e.g., cacao fat, uitepsols, produced by Dynamite Nobel Company, Germany), moderate fatty acids (e.g., MIGLYOL, produced by Dynamite Nobel Company, Germany), and vegetable oils (e.g., sesame oil, soybean oil, cottonseed oil). Aqueous bases include, for example, polyethylene glycols and propylene glycol. Bases for aqueous gels include, for example, natural rubbers, cellulose derivatives, vinyl polymers and acrylic acid polymers.

#### BEST MODE FOR CARRYING OUT THE INVENTION

The present invention is hereinafter described in more detail by means of, but is not limited to, the following reference examples, examples, preparation examples and experimental examples.

$^1\text{H}$ -NMR spectra are determined with tetramethylsilane as the internal standard, using the GEMINI 200 (200 MHz) spectrometer (produced by Varian, Ltd.), the LAMBDA 300 (300 MHz) spectrometer (produced by JEOL, Ltd.) or the Bruker AM500 (500 MHz) spectrometer (produced by Bruker); all  $\delta$  values are shown in ppm. Unless otherwise specifically indicated, "%" is by weight. Yield indicates mol/mol %.

The symbols used herein have the following definitions:

s: singlet  
d: doublet  
t: triplet  
dt: double triplet  
m: multiplet  
br: broad

The term "at room temperature" indicates the range from about 15 to 25 °C, but is not to be construed as strictly limitative.

## Examples

## Reference Example 1

Production of 2-amino-5-phenylthiophen-3-carboxylic acid ethyl ester

5 To a mixture of ethyl cyanoacetate (6.1 g, 50 mmol), sulfur (1.61 g, 50 mmol), triethylamine (3.5 ml, 25 mmol), and dimethylformamide (10 ml), phenylacetaldehyde (50% solution in diethyl phthalate; 12.05 g, 50 mmol) was added dropwise with stirring at 45 °C over 20 minutes. After  
10 stirring at 45 °C for 9 hours, the reaction mixture was concentrated and the obtained residue was extracted with ethyl acetate, washed with saline and dried (MgSO<sub>4</sub>), the solvent was distilled off under reduced pressure. The residue was chromatographed on silica gel and recrystallized  
15 from ether-hexane to yield pale yellow tabular crystals (5.55 g, 45%).

mp 124.5-125.5 °C (lit.; 123-124 °C).

Elemental analysis for C<sub>13</sub>H<sub>13</sub>NO<sub>2</sub>S

C (%) H (%) N(%)

20 Calculated : 63.13 ; 5.30 ; 5.66

Found : 62.99 ; 5.05 ; 5.63

<sup>1</sup>H-NMR (300MHz, CDCl<sub>3</sub>) δ: 1.37 (3H, t, J=7.1Hz), 4.30 (2H, d, J=7.1Hz), 5.97 (2H, br), 7.17-7.46 (6H, m).

IR (KBr): 3448, 3320, 1667, 1590, 1549 cm<sup>-1</sup>.

25

## Reference Example 2

Production of 2-amino-4-methyl-5-(4-methoxyphenyl)thiophen-3-carboxylic acid ethyl ester

30 A mixture of 4-methoxyphenylacetone (16.5 g, 0.10 mol), ethyl cyanoacetate (12.2 g, 0.10 mol), ammonium acetate (1.55 g, 20 mmol), acetic acid (4.6 ml, 80 mmol), and benzene (20 ml) was heated and refluxed for 24 hours, while the water being produced was removed using a Dean-Stark apparatus. After cooling, the reaction mixture was concentrated under reduced

pressure and the residue was partitioned between dichloromethane and aqueous sodium bicarbonate. After the organic layer was washed with saline and dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure. To a solution in ethanol (30 ml) of the obtained residue, were added sulfur (3.21 g, 0.10 mol) and diethylamine (10.4 ml, 0.10 mol), followed by stirring at 50 to 60 °C for 2 hours, successively the reaction mixture was concentrated. The obtained residue was extracted with ethyl acetate, washed with saline and dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure. The residue was chromatographed on silica gel and recrystallized from ether-hexane to yield light yellow tabular crystals (11.5 g, 40%). mp 79-80 °C.

15 Elemental analysis for  $\text{C}_{15}\text{H}_{17}\text{NO}_3\text{S}$

C (%) H (%) N (%) S (%)

Calculated : 61.83 ; 5.88 ; 4.81 ; 11.01

Found : 61.81 ; 5.75 ; 4.74 ; 10.82

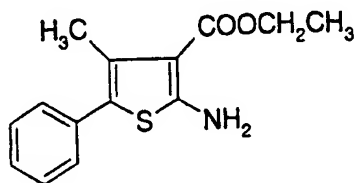
$^1\text{H-NMR}$  (200MHz,  $\text{CDCl}_3$ )  $\delta$ : 1.37 (3H, t,  $J=7.1\text{Hz}$ ), 2.28 (3H, s), 3.83 (3H, s), 4.31 (2H, q,  $J=7.1\text{Hz}$ ), 6.05 (2H, brs), 6.91 (2H, d,  $J=8.8\text{Hz}$ ), 7.27 (2H, d,  $J=8.8\text{Hz}$ ).

IR (KBr): 3426, 3328, 1651, 1586, 1550, 1505, 1485  $\text{cm}^{-1}$ .

FAB-MS  $m/z$ : 291 ( $\text{M}^+$ ).

25 Reference Example 3

Using some acetone derivatives in place of 4-methoxyphenylacetone, the following compound was obtained in the same manner as in Reference Example 2.



Yield: 40%  
mp 64-65 °C.

#### Reference Example 4

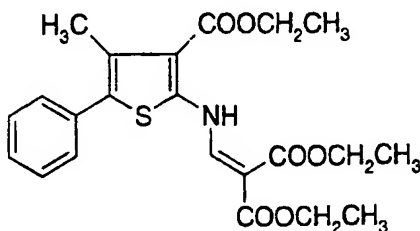
- 5           Production of [3-ethoxycarbonyl-5-(4-methoxyphenyl)-  
4-methylthiophen-2-yl]aminomethylenemalononic acid diethyl  
ester

To the compound obtained in Reference Example 2 (10 g,  
34.3 mmol), ethoxymethylenemalononic acid diethyl ester (7.45  
10 g, 34.5 mmol) was added, followed by stirring at 120 °C for  
2 hours. After the reaction mixture was cooled, the crystal  
precipitated was collected by filtration via the addition of  
ether, again washed with ether, and dried over phosphorus  
pentaoxide under reduced pressure to yield yellow crystals  
15 (14.2 g, 90%).  
mp 122-123 °C.

$^1\text{H-NMR}$  (200MHz,  $\text{CDCl}_3$ )  $\delta$ : 1.32 (3H, t,  $J=7.1\text{Hz}$ ), 1.38 (3H,  
t,  $J=7.2\text{Hz}$ ), 1.41 (3H, t,  $J=7.2\text{Hz}$ ), 2.34 (3H, s), 3.85 (3H,  
s), 4.25 (2H, q,  $J=7.1\text{Hz}$ ), 4.38 (2H, q,  $J=7.2\text{Hz}$ ), 4.45 (2H,  
20 q,  $J=7.2\text{Hz}$ ), 6.95 (2H, d,  $J=8.8\text{Hz}$ ), 7.31 (2H, d,  $J=8.8\text{Hz}$ ),  
8.22 (1H, d,  $J=13.4\text{Hz}$ ), 12.74 (1H, d,  $J=13.1\text{Hz}$ ).  
IR (KBr): 2984, 1720, 1707, 1688, 1653, 1599, 1518, 1499  
 $\text{cm}^{-1}$ .

#### 25   Reference Example 5

Using the compound obtained in Reference Example 3 as  
a starting material, the following compound was obtained in  
the same manner as in Reference Example 4.



Yield: 92%

mp 108-109 °C.

Reference Example 6

5        Production of 3-carboxy-5-[(4-methoxyphenyl)-4-methylthiophen-2-yl]aminomethylenemalonic acid diethyl ester

10        To a solution in dioxane (20 ml) of the compound obtained in Reference Example 4 (7.0 g, 15.2 mmol) was added, a solution of potassium hydroxide (5.0 g, 75.7 mmol) in ethanol (30 ml) with stirring at 60 to 70 °C. After stirring at this temperature for 1 hour, the reaction mixture was kept standing at room temperature for 1 hour. To the mixture was added 2 N hydrochloric acid (40 ml, 80 mmol) with ice cooling, the  
15        reaction mixture was concentrated under reduced pressure. The yellow precipitate was collected by filtration, washed with cold water-ethanol, and dried over phosphorus pentaoxide under reduced pressure to yield yellow powders (6.1 g, 93%). mp 184-187 °C.

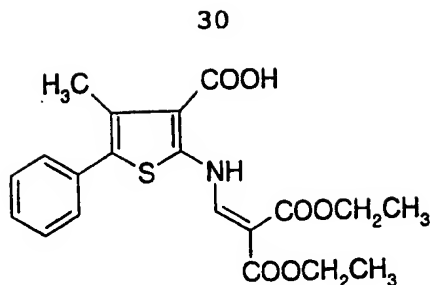
20        <sup>1</sup>H-NMR (200MHz, DMSO-d<sub>6</sub>) δ: 1.24 (3H, t, J=7.1Hz), 1.28 (3H, t, J=7.2Hz), 2.30 (3H, s), 3.80 (3H, s), 4.15 (2H, q, J=7.1Hz), 4.24 (2H, q, J=7.2Hz), 7.03 (2H, d, J=8.7Hz), 7.37 (2H, d, J=8.7Hz), 8.08 (1H, d, J=13.6Hz), 12.41 (1H, d, J=13.6Hz).  
IR (KBr): 3422, 2980, 1719, 1653, 1607, 1551, 1512 cm<sup>-1</sup>.

25

Reference Example 7

Using the compound obtained in Reference Example 5 as a starting material, the following compound was obtained in the same manner as in Reference Example 6.

30



Yield: 98%

mp 187-190 °C.

# 5 Reference Example 8

Production of 4-hydroxy-2-(4-methoxyphenyl)-3-methylthieno[2,3-b]pyridine-5-carboxylic acid ethyl ester

With stirring at 120 °C, small portions of the compound obtained in Reference Example 6 (6.0 g, 13.8 mmol) was added to polyphosphoric acid ester (PPE) (90 ml). After stirring at the same temperature for 30 minutes, the reaction mixture was poured into ice water and extracted with ethyl acetate. The combined extracts were washed with saline, and dried (MgSO<sub>4</sub>), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel to yield yellow powders (3.65 g, 77%). For a sample for elemental analysis, the powders obtained were recrystallized from ethanol to yield yellow crystals.

# 20 Elemental analysis for C<sub>18</sub>H<sub>17</sub>NO<sub>4</sub>S

	C (%)	H (%)	N (%)	S (%)
Calculated	62.96	4.99	4.08	9.34
Found	62.89	5.04	4.01	9.34

<sup>1</sup>H-NMR (200MHz, CDCl<sub>3</sub>) δ: 1.47 (3H, t, J=7.1Hz), 2.63 (3H, s), 4.87 (3H, s), 4.49 (2H, q, J=7.1Hz), 6.99 (2H, d, J=8.8Hz), 7.44 (2H, d, J=8.8Hz), 8.84 (1H, s), 12.11 (1H, s).

IR (KBr): 3434, 2992, 1692, 1601, 1582, 1535, 1504 cm<sup>-1</sup>.

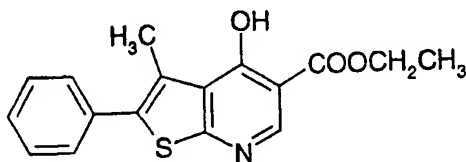
FAB-MS m/z: 344 (MH<sup>+</sup>).



## Reference Example 9

Using the compound obtained in Reference Example 7 as a starting material, the following compound was obtained in the same manner as in Reference Example 8.

5



Yield: 60%

mp 155-157 °C.

## 10 Reference Example 10

Production of 4-hydroxy-2-(4-nitrophenyl)-3-methylthieno[2,3-b]pyridine-5-carboxylic acid ethyl ester

To a solution in concentrated sulfuric acid (10 ml) of the compound obtained in Reference Example 9 (3.76 g, 12.0 mmol) was added dropwise a solution of sodium nitrate (1.27 g, 15.0 mmol) in concentrated sulfuric acid (5 ml) with ice cooling. After stirring at this temperature for 30 minutes, the reaction mixture was poured into ice water and extracted with chloroform. The combined extracts were washed with saline, and dried (MgSO<sub>4</sub>), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel to yield yellow powders, which was recrystallized from ethanol to yield yellow crystals (1.75 g, 41%).

25 mp 260-261 °C.

Elemental analysis for C<sub>17</sub>H<sub>14</sub>N<sub>2</sub>O<sub>5</sub>S

C (%) H (%) N (%)

Calculated : 56.98 ; 3.94 ; 7.82

Found : 56.66 ; 3.91 ; 7.86

30 <sup>1</sup>H-NMR (200MHz, CDCl<sub>3</sub>) δ: 1.49(3H, t, J=7.1Hz), 2.70(3H, s), 4.51 (2H, q, J=7.1Hz), 7.70(2H, d, J=8.8Hz), 8.34(2H, d,

$J=8.8\text{Hz}$ ), 8.89(1H, s), 12.27(1H, s).

IR (KBr): 3002, 1692, 1605, 1514, 1350, 1290  $\text{cm}^{-1}$ .

FAB-MS  $m/z$ : 358 ( $\text{MH}^+$ ).

5 Reference Example 11

Production of 4,7-dihydro-7-(2-methoxybenzyl)-2-(4-methoxyphenyl)-3-methyl-4-oxothieno[2,3-b]pyridine-5-carboxylic acid ethyl ester

To a suspension of sodium hydride (60% dispersion in oil; 123 mg, 3.08 mmol) in dimethylformamide (3 ml) was added a solution of the compound obtained in Reference Example 8 (1.0 g, 2.91 mol) in dimethylformamide (20 ml) under nitrogen stream with ice cooling. After stirring at this temperature for 30 minutes, to the mixture was added dropwise a solution of 2-methoxybenzyl chloride (0.92 g, 5.87 mmol) in dimethylformamide (3 ml). After stirring at room temperature for 23 hours and at 70 °C for 2 hours, the reaction mixture was concentrated, and then the obtained residue was partitioned between ethyl acetate and an aqueous solution of ammonium chloride. The water layer was extracted with ethyl acetate. The combined extracts were washed with saline, and dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel to yield light yellow amorphous powders (0.95 g, 70%). For a sample for elemental analysis, the obtained powders were recrystallized from dichloromethane-ether to yield yellow prismatic crystals.

mp 165-167 °C.

Elemental analysis for  $\text{C}_{26}\text{H}_{25}\text{NO}_5\text{S} \cdot 0.5\text{H}_2\text{O}$

30 C (%) H (%) N (%)

Calculated : 66.08 ; 5.55 ; 2.96

Found : 66.33 ; 5.44 ; 2.74

$^1\text{H-NMR}$  (200MHz,  $\text{CDCl}_3$ )  $\delta$ : 1.41(3H, t,  $J=7.1\text{Hz}$ ), 2.65(3H, s), 3.85(3H, s), 3.86(3H, s), 4.39(2H, q,  $J=7.1\text{Hz}$ ), 5.16(2H, s).

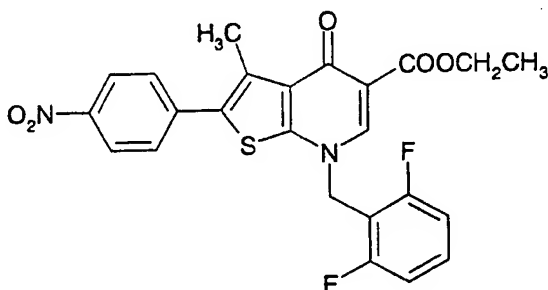
6.92-7.00(4H, m), 7.21-7.41(4H, m), 8.41(1H, s).

IR (KBr): 2980, 1727, 1684, 1609, 1590, 1497, 1464  $\text{cm}^{-1}$ .

#### Reference Example 12

5        The following compound was produced by the same method as described in Reference Example 11, using benzyl 2,6-difluorochloride in place of 2-methoxybenzyl chloride with the compound obtained in Reference Example 10 as the starting material.

10



Yield: 81%

mp 215-217 °C.

#### 15        Reference Example 13

Production of 3-bromomethyl-4,7-dihydro-7-(2-methoxybenzyl)-2-(4-methoxyphenyl)-4-oxothieno[2,3-b]pyridine-5-carboxylic acid ethyl ester

20        A mixture of the compound obtained in Reference Example 11 (0.35 g, 0.755 mmol), N-bromosuccinimide (0.135 g, 0.758 mmol),  $\alpha,\alpha'$ -azobisisobutyronitrile (13 mg, 0.079 mmol), and carbon tetrachloride (5 ml) was heated and refluxed for 2 hours. After cooling, the insoluble substances were filtered off, and then the filtrate was diluted with  
25        chloroform. After the organic layer was washed with saline and dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure. The obtained residue was recrystallized from ethyl acetate to yield colorless needles (0.272 g, 66%).

mp 200-201 °C.

Elemental analysis for  $C_{26}H_{24}NO_5SBr$

C (%) H (%) N (%)

Calculated : 57.57 ; 4.46 ; 2.58

5 Found : 57.75 ; 4.31 ; 2.31

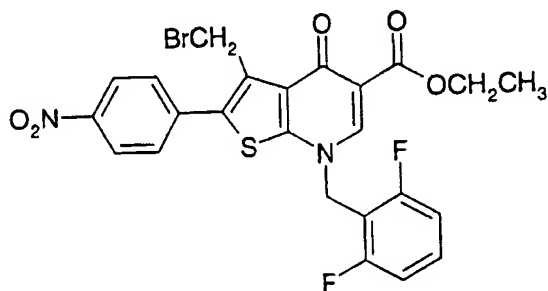
$^1H$ -NMR (200MHz,  $CDCl_3$ )  $\delta$ : 1.40(3H, t,  $J=7.1Hz$ ), 3.86(6H, s),  
4.40(2H, q,  $J=7.1Hz$ ), 5.05(2H, s), 5.16(2H, s), 6.92-7.04(4H,  
m), 7.23-7.28(1H, m), 7.34-7.43(1H, m), 7.57(2H, d,  $J=8.9Hz$ ),  
8.46(1H, s).

10 IR (KBr): 2980, 1725, 1607, 1588, 1497  $cm^{-1}$ .

#### Reference Example 14

Using the compounds obtained in Reference Examples 12,  
22 and 27 as a starting material, respectively, the following  
15 compounds (Reference Examples 14-1 to 14-3) were obtained in  
the same manner as in Reference Example 13.

#### Reference Example 14-1:



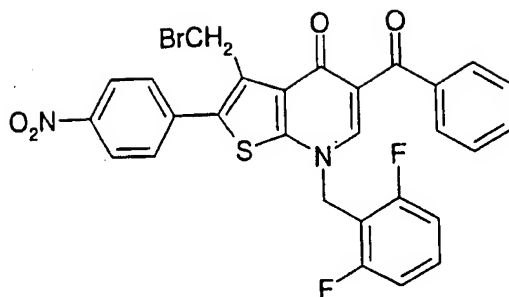
20

Yield: 81%

mp 200-202 °C.

#### Reference Example 14-2:

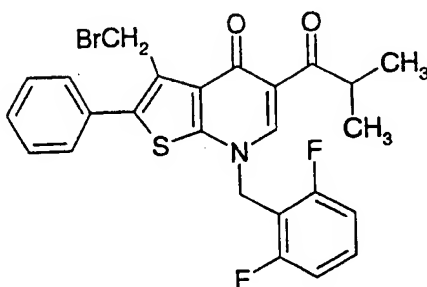
35



Yield: 80%

Amorphous.

## 5 Reference Example 14-3:



Yield: 79%

mp 189-192 °C.

10

## Reference Example 15

Production of 3-benzylaminomethyl-4,7-dihydro-7-(2-methoxybenzyl)-2-(4-methoxyphenyl)-4-oxothieno[2,3-b]pyridine-5-carboxylic acid ethyl ester hydrochloride

15 To a solution of the compound obtained in Reference Example 13 (0.245 g, 0.452 mmol) in dimethylformamide (5 ml) were added triethylamine (0.10 ml, 0.717 mmol) and benzylamine (80  $\mu$ l, 0.732 mmol) with ice cooling. After stirring at room temperature for 1.5 hours, the reaction mixture was concentrated, and then the obtained residue was

20 partitioned between ethyl acetate and saturated aqueous sodium bicarbonate. The water layer was extracted with ethyl acetate. The combined organic extracts were dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure. The

obtained residue was chromatographed on silica gel to yield a colorless oil (0.135 g, 53%). To a solution of this oil in ethanol (4 ml) was added 10 N ethanolic hydrochloric acid (0.2 ml) with ice cooling, followed by stirring at this temperature for 10 minutes. The reaction mixture was concentrated, and then the obtained residue was crystallized from ethyl acetate-ether to yield the hydrochloride (0.113 g) as white crystals.

mp [Hydrochloride] 118-119 °C.

10 Elemental analysis for  $C_{33}H_{32}N_2O_5S \cdot HCl \cdot 0.9H_2O$

C (%) H (%) N (%)

Calculated : 63.79 ; 5.64 ; 4.51

Found : 64.03 ; 5.44 ; 4.51

$^1H$ -NMR (300MHz,  $CDCl_3$ ) [Free amine]  $\delta$ : 1.40(3H, t,  $J=7.1Hz$ ), 2.05(1H, br), 3.81(3H, s), 3.86(3H, s), 3.87(2H, s), 3.94(2H, s), 4.40(2H, q,  $J=7.1Hz$ ), 5.18(2H, s), 6.80(2H, d,  $J=8.8Hz$ ), 6.91-6.99(2H, m), 7.20-7.42(9H, m), 8.45(1H, s).  
IR (KBr) [Hydrochloride]: 3422, 2938, 1719, 1605, 1560, 1545, 1502, 1460  $cm^{-1}$ .

20

#### Reference Example 16

Production of 4-methyl-2-[(4-methyl-3-oxo-1-penten-1-yl)amino]-5-phenylthiophen-3-carboxylic acid ethyl ester

The compound obtained in Reference Example 3 (10 g), 1-methoxy-4-methyl-1-penten-3-one of 85% content (6.9 g), p-toluenesulfonic acid monohydrate (0.219 g), and toluene (100 ml) were mixed and stirred at room temperature for 2.5 hours. After the reaction mixture was diluted with ethyl acetate and washed with a saturated aqueous solution of sodium hydrogen carbonate, the water layer was extracted with ethyl acetate. The combined extracts were washed with saturated saline, the organic layers were dried over anhydrous magnesium sulfate. The residue was crystallized via the addition of a seed crystal, after which it was triturated with

hexane, collected by filtration, and washed, to yield the title compound (12.64 g, 92%).

mp 104-108 °C.

5 Reference Example 17

Production of 4,7-dihydro-7-(2-methoxybenzyl)-2-(4-methoxyphenyl)-3-methyl-4-oxothieno[2,3-b]pyridine-N-benzylpiperazinyl-5-carboxamide

To 1-benzylpiperazine (0.77 g, 4.37 mmol) was added  
10 dropwise a solution of diisobutyl aluminum hydride (DIBAL)  
in toluene (1.5 N, 2.9 ml, 4.37 mmol) with ice cooling. After  
the addition was completed, the solution was allowed to warm  
to room temperature and stirred for further 0.5 hours. To  
this solution was added a solution of the compound obtained  
15 in Reference Example 11 (0.50 g, 1.08 mmol) in toluene (5 ml)  
at room temperature. After the mixture was further stirred  
at room temperature for 15 hours, methylene chloride (30 ml)  
was added. After water washing, the solution was dried over  
sodium sulfate, and then the solvent was concentrated under  
20 reduced pressure to yield a solid (1.03 g), which was  
recrystallized from methylene chloride-n-hexane to yield the  
title compound (0.48 g, 78%).  
mp 233-235 °C.

Elemental analysis for  $C_{35}H_{35}N_3O_4S \cdot 1/2H_2O$

25 C (%) H (%) N (%) S (%)

Calculated : 69.75 ; 6.02 ; 6.97 ; 5.32.

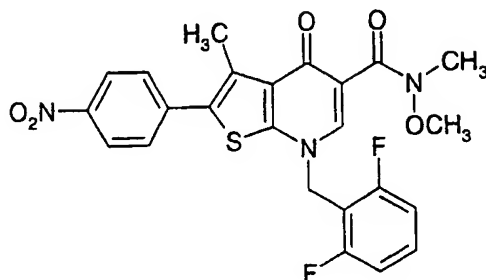
Found : 69.88 ; 6.06 ; 6.98 ; 5.39.

$^1H$ -NMR (300MHz,  $CDCl_3$ )  $\delta$ : 2.45-2.55(4H, m), 2.63(3H, s),  
3.43-3.49(2H, m), 3.55(2H, s), 3.73-3.82(2H, m), 3.84(6H, s),  
30 5.11(2H, s), 6.89-6.98(4H, m), 7.21-7.40(9H, m), 7.79(1H, s).

Reference Example 18

Using the compound obtained in Reference Example 12 as  
a starting material and N,O-dimethylhydroxy in place of  
35 1-benzylpiperazine, the following compound was obtained in

the same manner as in Reference Example 17.



Yield: 80%

5 mp 223-224 °C.

#### Reference Example 19

Production of 4-hydroxy-5-isobutyryl-3-methyl-2-phenylthieno[2,3-b]pyridine

10 The compound obtained in Reference Example 16 (50 g) and diphenyl ether (500 ml) were mixed, and then this mixture was heated and refluxed for 4 hours, while the ethanol being produced with the progress of the reaction was distilled off. After cooling, the diphenyl ether was distilled off under  
15 reduced pressure, and then the crude crystal precipitated was washed with n-hexane to yield the title compound (35.1 g, 81%).

mp 114-117 °C.

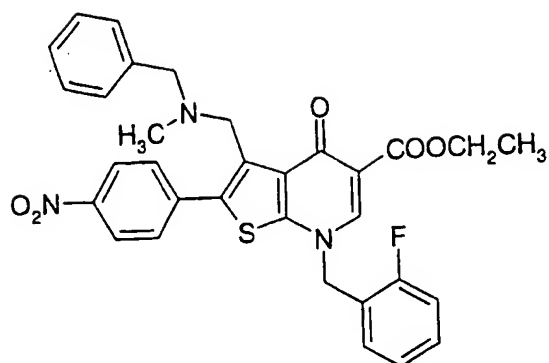
#### 20 Reference Example 20

Using the compound obtained in Reference Example 14-1 as starting material and N-methylbenzylamine in place of benzylamine, the following compounds (Reference Examples  
20-1 to 20-3) were obtained in the same manner as in Reference  
25 Example 15.

Reference Example 20-1:



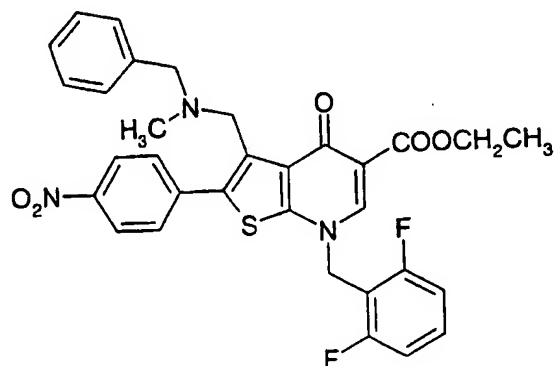
39



Yield: 83%

mp 140-144 °C.

## 5 Reference Example 20-2:

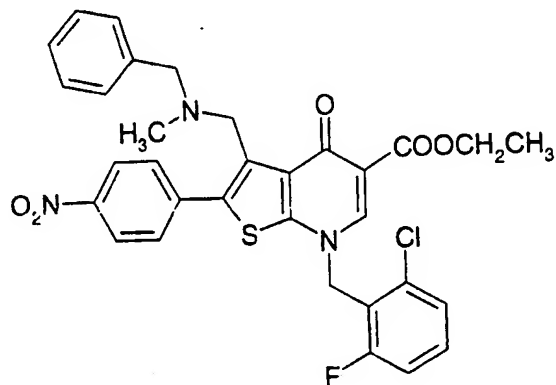


Yield: 91%

mp 145-147 °C.

10

## Reference Example 20-3:



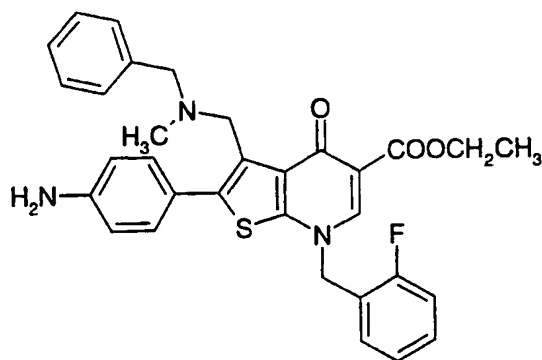
Yield: 78%

mp 175-177 °C.

Reference Example 21

- 5        Using the compounds obtained in Reference Example 20 as starting materials, the following compounds (Reference Examples 21-1 to 21-3) were obtained in the same manner as in Reference Example 28.

10      Reference Example 21-1:

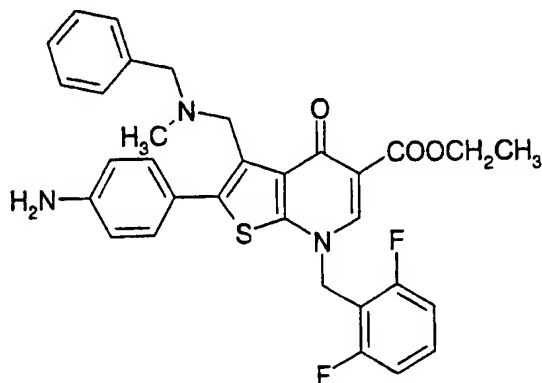


Yield: 79%

mp 158-160 °C.

15

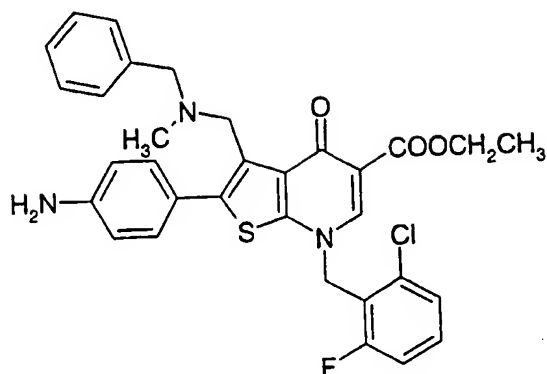
Reference Example 21-2:



Yield: 96%

20      mp 195-196 °C.

## Reference Example 21-3:



5      Yield: 71%  
      mp 144-146 °C.

## Reference Example 22

10      Production of 7-(2,6-difluorobenzyl)-4,7-dihydro-5-isobutyryl-3-methyl-4-oxo-2-phenyl-thieno[2,3-b]pyridine

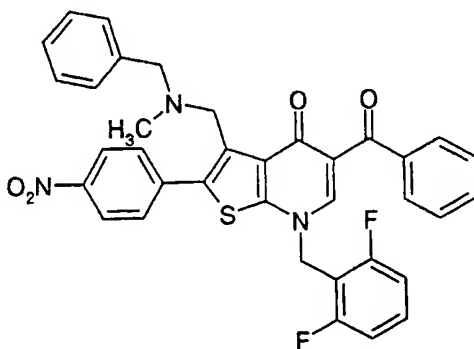
      The compound obtained in Reference Example 19 (35 g), potassium carbonate (18.6 g), and N,N-dimethylformamide (280 ml) were mixed, and then 2,6-difluorobenzyl bromide (27.9 g) was added, followed by stirring at room temperature for 4  
15      hours. To the reaction mixture was added dropwise water (560 ml), followed by stirring for 30 minutes, and then the mixture was stirred for 1 hour with ice cooling. The crude crystal was collected by filtration, washed with water, and dried, successively suspended in a 1:1 mixed solvent (250 ml) of  
20      ethyl acetate and diisopropyl ether and stirred at 25 to 40 °C for 1 hour, then stirred with ice cooling for 1 hour, the residual crystal was collected by filtration and washed with the above mixed solvent (125 ml) to yield the title compound (44.6 g, 92%).

25      mp 205-207 °C.

## Reference Example 23

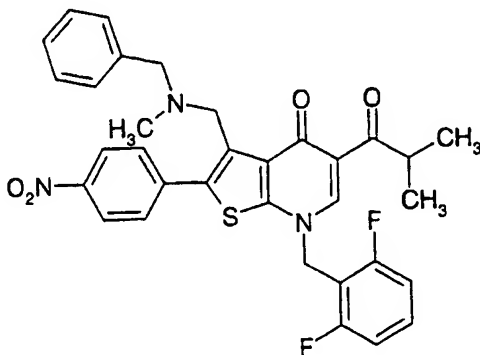
Using the compounds obtained in Reference Example 14-2 and Reference Example 24 as starting materials and N-methylbenzylamine in place of benzylamine, the following compounds (Reference Examples 23-1 to 23-2) were obtained in the same manner as in Reference Example 15.

## Reference Example 23-1:



Yield: 83%  
mp 197-199 °C.

## Reference Example 23-2:



Yield: 66%  
mp 151-152 °C.

## Reference Example 24

Production of 3-bromomethyl-7-(2,6-difluorobenzyl)-4,7-dihydro-5-isobutyryl-2-(4-nitrophenyl)-4-

oxothieno[2,3-b]pyridine

After the compound obtained in Reference Example 14-3 (1 g) was dissolved in methanesulfonic acid (5 ml) with cooling at 10 to 12 °C, a solution of sodium nitrate (0.165 g) in methanesulfonic acid (2.5 ml) was added dropwise to this mixture. After being stirred as was for 2 hours, the mixture was poured into cold water, and then the crystal precipitated was collected by filtration, washed with water and diisopropyl ether, and dried to yield a crude product (1.04 g), which was then triturated with ethyl acetate (15 ml), then cooled with ice, filtered, and washed with cold ethyl acetate to yield the title compound (0.647 g, 59.5%).  
mp 202 to 204 °C (recrystallized from methanol).

15 Reference Example 25

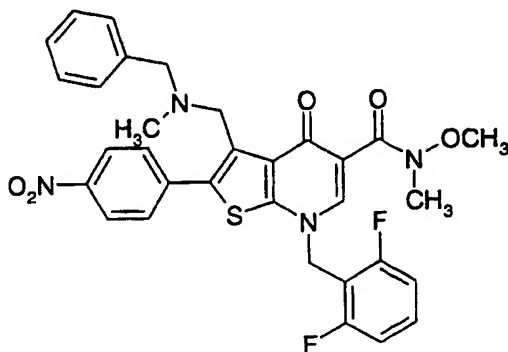
Production of 4,7-dihydro-7-(2,6-difluorobenzyl)-2-(4-nitrophenyl)-3-(N-benzyl-N-methylaminomethyl)-4-oxothieno[2,3-b]pyridine-5-(N-isopropyl)carboxamide

To a solution of isopropylamine (0.296 g, 5 mmol) in anhydrous methylene chloride (5 ml) was added dropwise a solution of trimethylaluminum in hexane (15%, 2.41 ml, 5.0 mmol) at 0 °C. After the addition was completed, the solution was allowed to warm to room temperature and further stirred for 1 hour. To this solution was added a solution of the compound obtained in Reference Example 20-2 (0.12 g, 0.25 mmol) in anhydrous methylene chloride (3 ml) with ice cooling (0 °C) over 30 minutes. After the mixture was stirred at room temperature for further 1 hour, chloroform (50 ml) was added, followed by washing with water. The combined organic layers were dried with sodium sulfate, and then the solvent was concentrated under reduced pressure to yield a solid, which was recrystallized from chloroformethyl acetate-ethyl ether to yield colorless crystals (0.096 g, 70%).  
mp 200-202 °C.

$^1\text{H-NMR}$  (500MHz,  $\text{CDCl}_3$ ) [Free amine]  $\delta$ : 1.30(6H, d,  $J=6.7\text{Hz}$ ),  
 2.15(3H, s), 3.66(2H, s), 4.18(2H, s), 4.18-4.31(1H, m),  
 5.32(2H, s), 7.00(2H, t,  $J=7.26\text{Hz}$ ), 7.13-7.25(5H, m),  
 7.42(1H, t,  $J=7.3\text{Hz}$ ), 8.02(2H, d,  $J=8.9\text{Hz}$ ), 8.26(2H, d,  
 5  $J=8.9\text{Hz}$ ), 8.73(1H, s), 10.02(1H, d,  $J=9.1\text{Hz}$ ).  
 IR (KBr) : 2974, 1661, 1597, 1547, 1497, 1346, 1212, 1035  $\text{cm}^{-1}$   
 FAB-Mass  $m/z$  617(MH) $^+$

## Reference Example 26

10 Using the compound obtained in Reference Example 20-2 as a starting material and N,O-dimethylhydroxyamine, the following compound was obtained in the same manner as in Reference Example 25.



15 Yield: 96%  
 mp 100-102  $^{\circ}\text{C}$ .

## Reference Example 27

20 Production of 4,7-dihydro-7-(2,6-difluorobenzyl)-2-(4-nitrophenyl)-5-benzoyl-3-methyl-4-oxothieno[2,3-b]pyridine

The compound obtained in Reference Example 18 (3.93 g, 7.87 mmol) was dissolved in anhydrous tetrahydrofuran (THF) (300 ml) with slightly warming. While this solution was kept  
 25 at 0  $^{\circ}\text{C}$ , a solution of phenylmagnesium bromide in THF (1 M, 15.7 ml, 15.7 mmol) was added dropwise to the mixture over 10 minutes. After the addition was completed, the solution

was stirred for further 1 hour. The reaction mixture was partitioned between ethyl acetate (300 ml) and water (50 ml), and then the water layer was again extracted with ethyl acetate. The combined organic layers were dried with magnesium sulfate, the solvent was concentrated under reduced pressure to yield a residue, which was chromatographed on silica gel to yield yellow crystals (3.00 g, 74%), which was then recrystallized from ethyl acetate-hexane to give yellow crystals.

mp 114-116 °C.

Elemental analysis for  $C_{28}H_{18}N_2O_4SF_2 \cdot 0.7H_2O$

C (%) H (%) N (%)

Calculated : 63.56 ; 3.70 ; 5.29

Found : 63.83 ; 3.95 ; 5.08

$^1H$ -NMR (500MHz,  $CDCl_3$ )  $\delta$ : 2.68(3H, s), 5.30(2H, s), 7.02(2H, t,  $J=8.1$ Hz), 7.43(3H, t,  $J=7.2$ Hz), 7.52-7.63(3H, m), 7.86(2H, d,  $J=7.5$ Hz), 7.99(1H, s), 8.30(2H, d,  $J=8.7$ Hz).

IR (KBr): 3422, 3068, 1665, 1615, 1491, 1473, 1346, 853  $cm^{-1}$ .

FAB-Mass  $m/z$  517(MH)<sup>+</sup>

#### Reference Example 28

Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-7-(2,6-difluorobenzyl)-2-(4-aminophenyl)-5-benzoyl-4-oxothieno[2,3-b]pyridine

To a mixture of the compound obtained in Reference Example 23-1 (0.30 g, 0.47 mmol) in ethyl alcohol (6 ml) were added water (2 ml), and then one drop of concentrated hydrochloric acid was added to yield a uniform solution. To this solution were added iron powder (0.105 g, 2.0 mmol) and concentrated hydrochloric acid (0.39 ml, 4.7 mmol) carefully. After the addition was completed, the mixture was stirred at room temperature for 5 hours and filtered through Celite. A small amount of aqueous ammonia was added, and then the reaction filtrate was concentrated under reduced pressure.

The obtained residue was poured into ice water, neutralized with sodium bicarbonate, and extracted with ethyl acetate. After the combined organic layers were washed with saline, and dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced  
5 pressure. The obtained residue was chromatographed on silica gel and recrystallized from isopropyl ether to yield yellow needles (0.24 g, 84%).

mp 126-128 °C.

Elemental analysis for  $\text{C}_{36}\text{H}_{29}\text{N}_3\text{O}_2\text{SF}_2 \cdot 1/2\text{H}_2\text{O}$

10 C (%) H (%) N (%)

Calculated : 68.93 ; 5.04 ; 6.70

Found : 68.71 ; 5.18 ; 6.62

$^1\text{H-NMR}$  (300MHz,  $\text{CDCl}_3$ )  $\delta$ : 2.13 (3H, s), 3.65 (2H, s), 3.87 (2H, br s), 4.14 (2H, s), 5.28 (2H, s), 6.74 (2H, d,  $J=8.7\text{Hz}$ ),  
15 7.00 (2H, t,  $J=7.8\text{Hz}$ ), 7.16-7.24 (5H, m), 7.36-7.46 (3H, m), 7.53 (1H, t,  $J=7.2\text{Hz}$ ), 7.62 (2H, d,  $J=8.4\text{Hz}$ ), 7.89 (2H, d,  $J=7.2\text{Hz}$ ), 7.94 (1H, s).

IR (KBr) : 3358, 1607, 1495, 1473, 1035  $\text{cm}^{-1}$ .

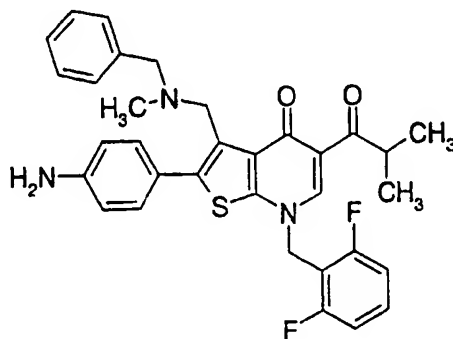
FAB-Mass  $m/z$  606(MH) $^+$

20

Reference Example 29

Production of 2-(4-aminophenyl)-7-(2,6-difluorobenzyl)-4,7-dihydro-5-isobutyryl-3-(N-benzyl-N-methylaminomethyl)-4-oxothieno[2,3-b]pyridine

25





To a solution of the compound obtained in Reference Example 23-2 (0.25 g, 0.415 mmol) in methanol (5 ml) were added dropwise iron powder (0.093 g, 1.66 mmol) and concentrated hydrochloric acid (0.8 ml) with ice cooling. After the addition was completed, the mixture was stirred at room temperature for 1 hour and filtered through Celite. A small amount of a saturated aqueous solution of sodium hydrogen carbonate (10 ml) was added, followed by extraction with methylene chloride (30 ml  $\times$  3). The combined extracts were washed with saline, and dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel to yield light yellow amorphous powders (0.203 g, 86%).

$^1\text{H-NMR}$ (300MHz,  $\text{CDCl}_3$ ) $\delta$ : 1.18(6H, d), 2.11(3H, s), 3.65(2H, s), 3.85(2H, br s), 4.17(2H, s), 4.18(1H, m), 5.25(2H, s), 6.73(2H, d), 6.95(2H, t), 7.10-7.26(5H, m), 7.42(1H, m), 7.58(2H, d), 8.27(1H, s).

#### Reference Example 30

Production of 5-benzoyl-7-(2,6-difluorobenzyl)-4,7-dihydro-3-(N-benzyl-N-methylaminomethyl)-2-(4-propionylaminophenyl)-4-oxothieno[2,3-b]pyridine

The compound obtained in Reference Example 28 (0.14 g, 0.23 mmol) was dissolved in anhydrous methylene chloride (2 ml), and then to the mixture was added triethylamine (0.038 ml) with ice cooling (0 °C). After this solution was stirred for a while, to the mixture was added propionyl chloride (0.021 ml, 0.243 mmol). After the addition was completed, the solution was further stirred with ice cooling (0 °C) for 40 minutes. The reaction mixture was partitioned between methylene chloride (25 ml) and very thinly overlaid water (10 ml). The water layer was again extracted with methylene chloride (25 ml). The combined organic layers were washed with saline, and dried ( $\text{MgSO}_4$ ), the solvent was distilled off

under reduced pressure. The solid obtained was recrystallized from ethyl acetate-isopropyl ether to yield yellow needles (0.10 g, 65%).

mp 226-228 °C.

- 5 Elemental analysis for  $C_{39}H_{33}N_3O_3SF_2 \cdot 0.7H_2O$

C (%) H (%) N (%)

Calculated : 69.46 ; 5.14 ; 6.23

Found : 69.60 ; 5.18 ; 6.04

- 10 Thus obtained compound was dissolved in ethyl acetate, and then a saturated solution of hydrogen chloride (HCl) in ether was added in equal to slightly excess amount, and then the crystal precipitated was recrystallized from isopropyl ether to yield light yellow needles (0.095 g, 61%).

- 15 mp 218-220 °C.

Elemental analysis for  $C_{39}H_{33}N_3O_3SF_2 \cdot HCl \cdot 3.5H_2O$

C (%) H (%) N (%)

Calculated : 61.53 ; 5.43 ; 5.52

Found : 61.83 ; 5.33 ; 5.30

- 20  $^1H$ -NMR (300MHz, DMSO- $d_6$ )  $\delta$ : 1.11(3H, t,  $J=7.2Hz$ ), 1.93(3H, s), 2.35(2H, q,  $J=7.5Hz$ ), 3.44(2H, s), 4.00(2H, s), 5.62(2H, s), 7.11-7.25(6H, m), 7.43-7.72(10H, m), 7.79(2H, d,  $J=7.5Hz$ ), 8.40(1H, s), 10.03(1H, s).

IR (KBr) : 3422, 3068, 1603, 1502, 1473, 1035  $cm^{-1}$ .

- 25 FAB-Mass  $m/z$  662(MH) $^+$

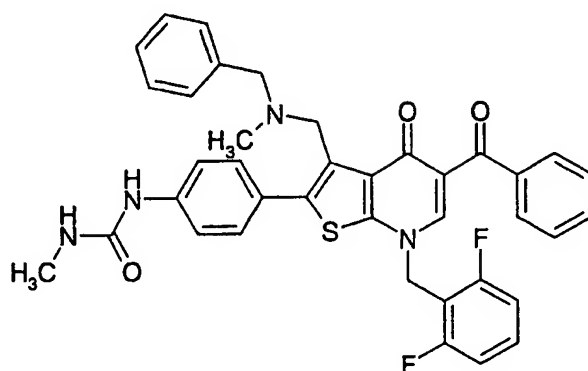
#### Reference Example 31

- 30 The following compounds (Reference Examples 31-1 through 31-10) were produced by the same method as described in Reference Example 30, using various acid chlorides, isocyanates, and chlorocarbonic acid esters in place of propionyl chloride, and also using the amines shown in Example 16 and carbonyldiimidazole, with the compounds obtained in Reference Examples 28 and 29 as the starting materials. The

following compounds (Reference Examples 31-11 through 31-16) can also be produced in the same manner.

Reference Example 31-1-1:

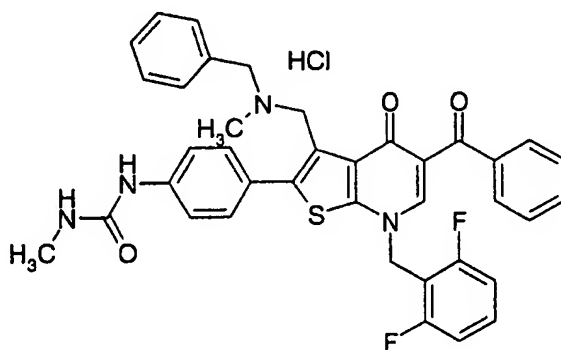
5



Yield: 68%

mp 238-240 °C.

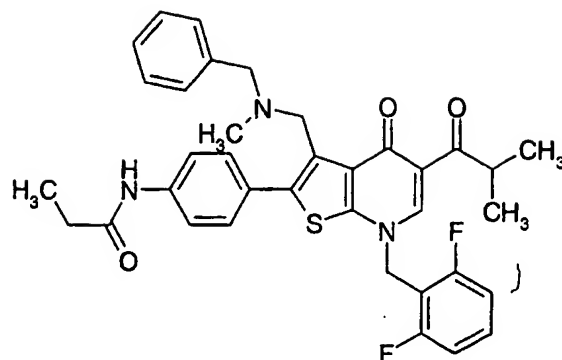
10 Reference Example 31-1-2:



mp 230-232 °C.

15 Reference Example 31-2-1:

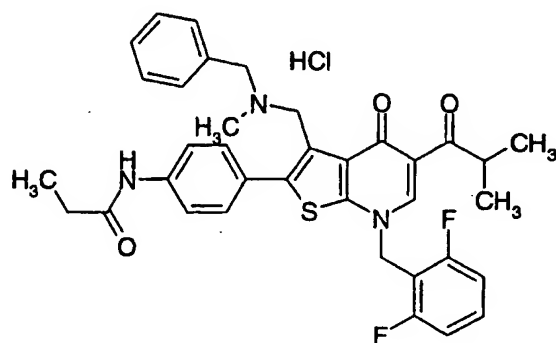
50



Yield: 64%

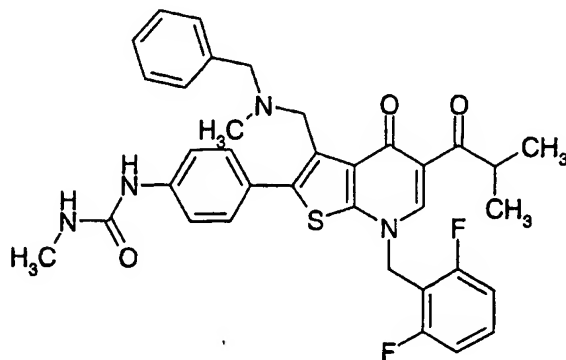
mp 201-204 °C.

## 5 Reference Example 31-2-2:



mp 207-214 °C.

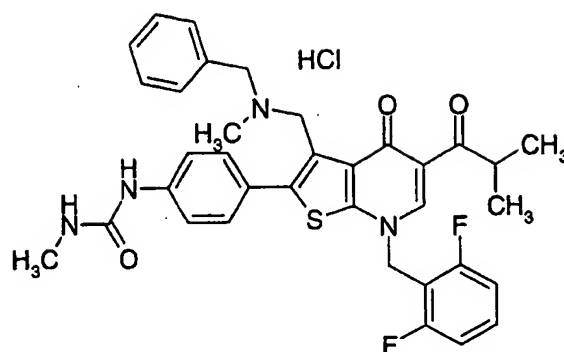
## 10 Reference Example 31-3-1:



Yield: 55%

mp 207-210 °C.

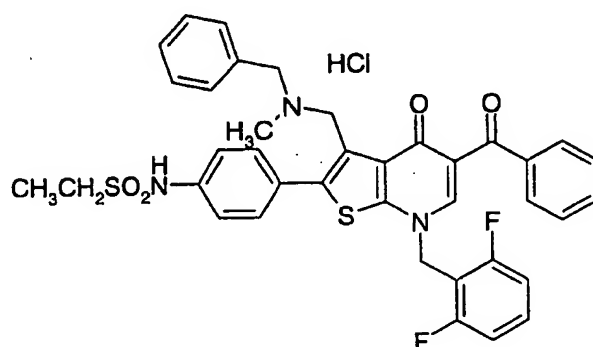
Reference Example 31-3-2:



5

mp 222-226 °C.

Reference Example 31-4:



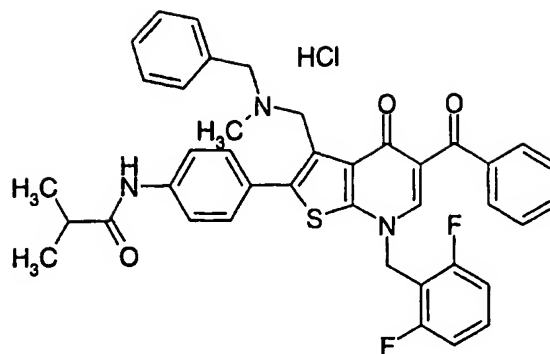
10

Yield: 49%

mp 185-187 °C.

Reference Example 31-5:

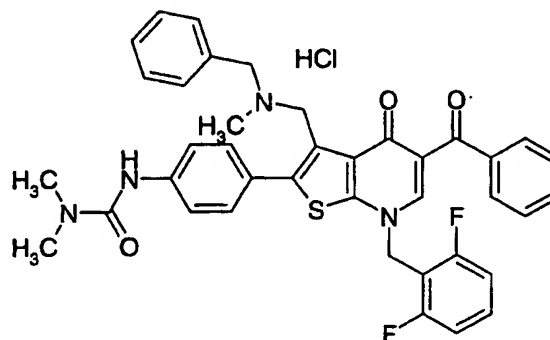
52



Yield: 79%

mp 216-218 °C.

5      Reference Example 31-6:

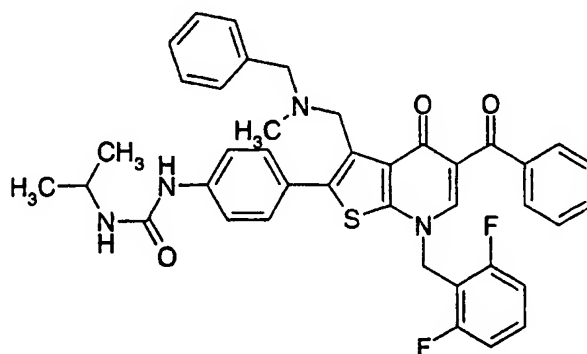


Yield: 73%

mp 180-183 °C.

10

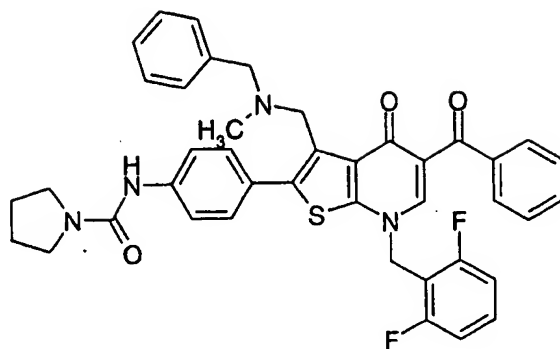
Reference Example 31-7:



**Yield:** 65%

mp 245-247 °C.

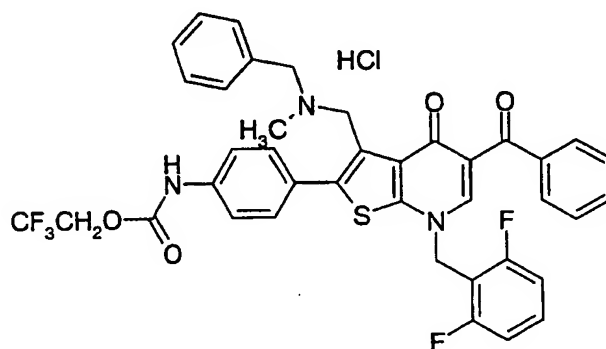
Reference Example 31-8:



5

Yield: 65%

Reference Example 31-9:



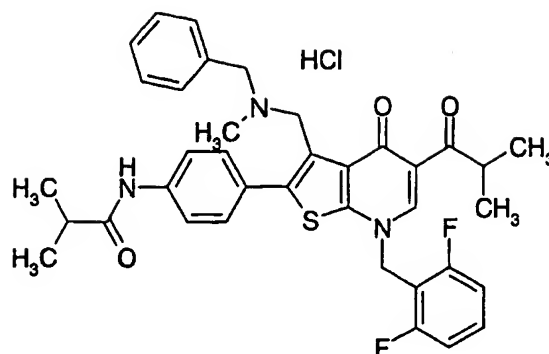
10

Yield: 70%

mp 232-234 °C.

Reference Example 31-10:

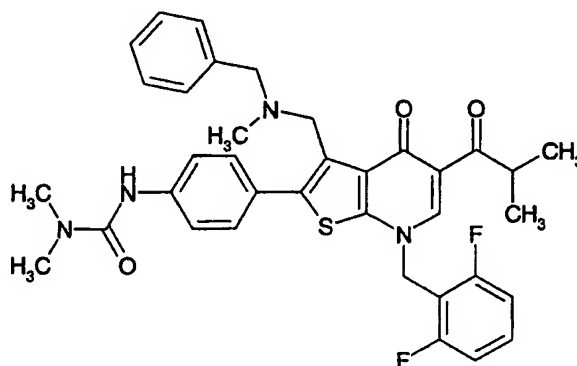
54



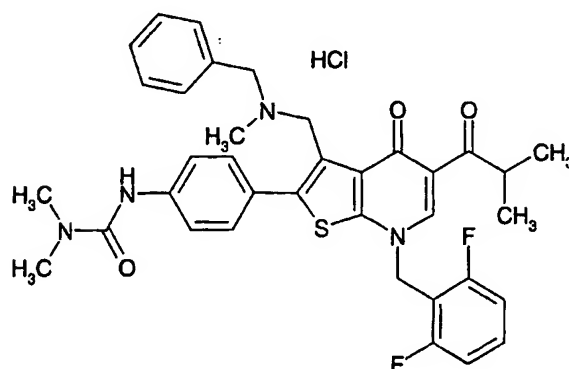
Yield: 73%

mp 192-197 °C.

## 5 Reference Example 31-11:



## Reference Example 31-12:

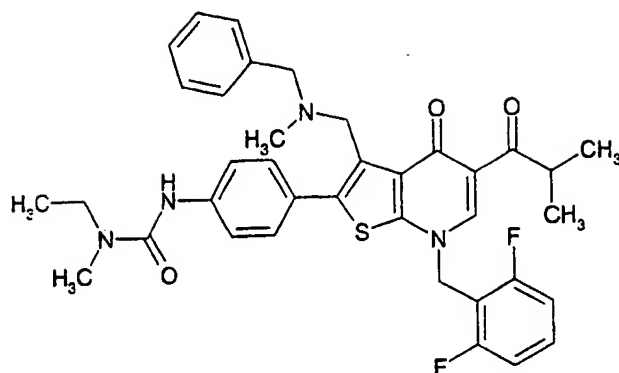


10

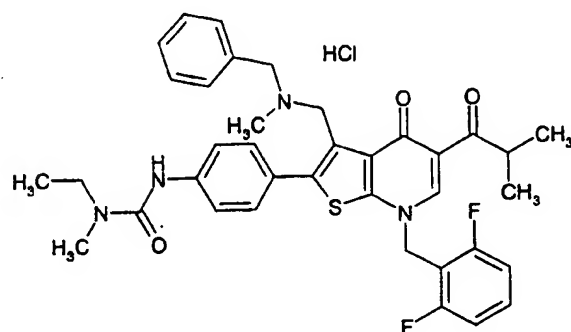
## Reference Example 31-13:



55

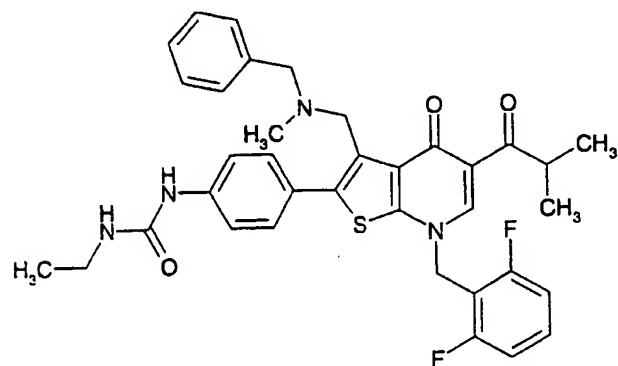


Reference Example 31-14:



5

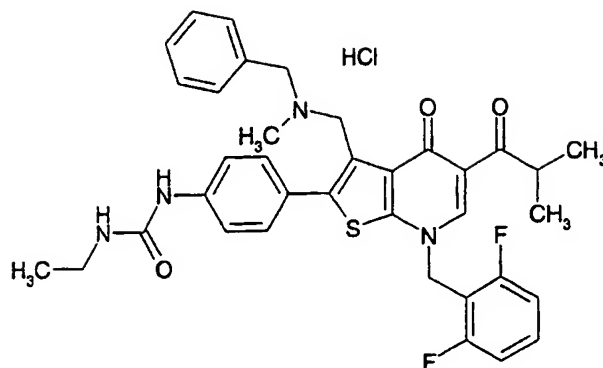
Reference Example 31-15:



10

Reference Example 31-16:

56



## Reference Example 32

5 Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-7-(2,6-difluorobenzyl)-2-(4-nitrophenyl)-5-benzoyl-4-oxothieno[2,3-b]pyridine

The compound obtained in Reference Example 26 (1.91 g, 3.09 mmol) was dissolved in anhydrous tetrahydrofuran (THF) (30 ml) with warming, and then to the mixture was added dropwise a solution of phenylmagnesium bromide in THF (1 M, 6.18 ml, 6.2 mmol) with ice cooling (0 °C) over 10 minutes. After stirring under ice cooling conditions for 1 hour, the reaction mixture was partitioned between ethyl acetate (100 ml) and aqueous hydrochloric acid (0.5 N, 100 ml), and then the organic layer was again washed with saturated saline (100 ml). After the organic layer was dried (MgSO<sub>4</sub>), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel to yield yellow crystals (1.00 g, 51%), which was then recrystallized from isopropyl ether to yield yellow needles.

mp 197-199 °C.

Elemental analysis for C<sub>36</sub>H<sub>27</sub>N<sub>3</sub>O<sub>4</sub>SF<sub>2</sub> 0.7H<sub>2</sub>O

C (%) H (%) N (%)

Calculated : 66.70 ; 4.42 ; 6.48

25 Found : 66.59 ; 4.48 ; 6.42

<sup>1</sup>H-NMR (300MHz, CDCl<sub>3</sub>) δ: 2.17(3H, s), 3.61(2H, s), 4.16(2H, s), 5.30(2H, s), 7.03(2H, t, J=8.1Hz), 7.19-7.25(5H, m),

7.40-7.47(3H, m), 7.56(1H, t, J=7.5Hz), 7.88(2H, d, J=6.9Hz),  
7.96(1H, s), 8.10(2H, d, J=8.7Hz), 8.28(2H, d, J=8.7Hz).  
IR (KBr) : 3430, 1663, 1611, 1518, 1473, 1348, 853  $\text{cm}^{-1}$ .  
FAB-Mass  $m/z$  636(MH)<sup>+</sup>

5

## Reference Example 33

Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-7-(2,6-difluorobenzyl)-2-(4-isobutyrylamino-phenyl)-5-(2-bromoisobutyryl)-4-oxothieno[2,3-b]pyridine

10

The compound obtained in Reference Example 31-10 (0.48 g, 0.75 mmol) was dissolved in dichloromethane (15 ml). To the solution was added dropwise 47% hydrobromic acid (0.35 ml, 3.0 mmol) at room temperature for 1 minute, followed by further stirring for 10 minutes. To this reaction mixture was added dropwise bromine (39  $\mu\text{l}$ , 0.75 mmol), followed by further stirring at room temperature for 24 hours. The reaction mixture was partitioned between dichloromethane (30 ml) and aqueous sodium bicarbonate (saturated, 60 ml), and then the organic layer was again washed with saturated saline (100 ml). After the organic layer was dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure to yield brown amorphous crystals (0.53 g).

15

20

25

## Reference Example 34

Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-7-(2,6-difluorobenzyl)-2-(4-isobutyrylamino-phenyl)-5-methacryloyl-4-oxothieno[2,3-b]pyridine

30

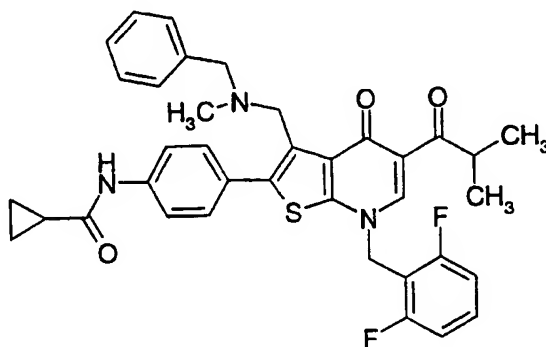
The compound obtained in Reference Example 33 (0.52 g, 0.72 mmol) was dissolved in dimethylformamide (DMF) (30 ml), and then to this solution was added potassium acetate (2.0 g, 20 mmol) at room temperature, followed by stirring at 100 °C for 20 hours. The reaction mixture was partitioned between

ethyl acetate (30 ml) and water (30 ml), and then the water layer was again washed with ethyl acetate (10 ml). The combined organic layers were again washed with saturated saline (30 ml). After the organic layer was dried ( $\text{MgSO}_4$ ),  
5 the solvent was distilled off under reduced pressure to yield a brown oil (0.56 g).

#### Example 1

##### Example 1-1:

10 Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-(4-cyclopropanecarbonylamino-phenyl)-4-oxothieno[2,3-b]pyridine



15

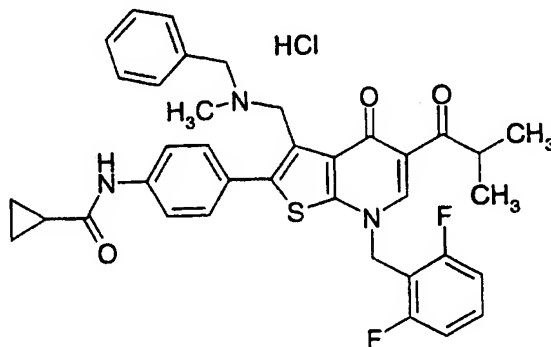
To a solution of the compound obtained in Reference Example 29 (2.57 g, 4.5 mmol) in dichloromethane (50 ml) were added cyclopropanecarboxylic acid (861 mg, 10 mmol) and diisopropylethylamine (2.59 g, 20 mmol), and then  
20 benzotriazol-1-yl-oxy tripyrrolidino phosphonium hexafluorophosphoric acid (PyBop) (5.40 g, 10 mmol) was added to it in a small portion with ice cooling. After stirring at room temperature for 1 day, the reaction mixture was poured into a 0.1 N aqueous solution of potassium hydroxide and  
25 extracted with chloroform. The combined extracts were washed with saline, and dried ( $\text{Na}_2\text{SO}_4$ ), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel and recrystallized from

ethyl acetate to yield white powdery crystals (2.15 g, 79%).  
 $^1\text{H-NMR}$  (300MHz,  $\text{CDCl}_3$ )  $\delta$ : 0.85-0.90(2H, m), 1.10-1.15(2H, m),  
 1.18(6H, d), 1.53-1.59(1H, m), 2.09(3H, s), 4.12-4.20(1H, m),  
 4.16(2H, s), 5.25(2H, s), 6.99(2H, t), 7.10-7.25(6H, m),  
 7.35-7.45(1H, m), 7.61(2H, d), 7.67(1H, br s), 7.76(2H, d),  
 8.27(1H, s).

FAB-Mass  $m/z$  608(MH) $^+$

#### Example 1-2:

Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-(4-cyclopropanecarbonylamino-phenyl)-4-oxothieno[2,3-b]pyridine hydrochloride



15

The white powdery crystals obtained in Example 1-1 were dissolved in ethanol, and then a solution of hydrogen chloride in ethyl ether was added to it in a small excess amount, followed by recrystallization from ethanol-ethyl ether, to yield white powdery crystals (2.20 g, 72%).  
 mp 254-256 °C.

Elemental analysis for  $\text{C}_{37}\text{H}_{35}\text{N}_3\text{O}_3\text{SF}_2 \text{ HCl}$

C (%) H (%) N (%)

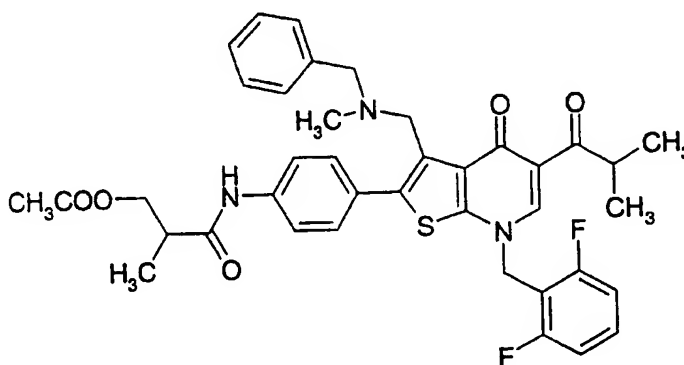
Calculated : 65.72 ; 5.37 ; 6.21

Found : 65.61 ; 5.38 ; 6.25

IR (KBr) : 2950, 1673, 1595, 1502, 1473, 1408, 1313, 1183  $\text{cm}^{-1}$ .

## Example 2

Production of 4,7-dihydro-2-[4-(3-acetoxy-2-methylpropionylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-b]pyridine

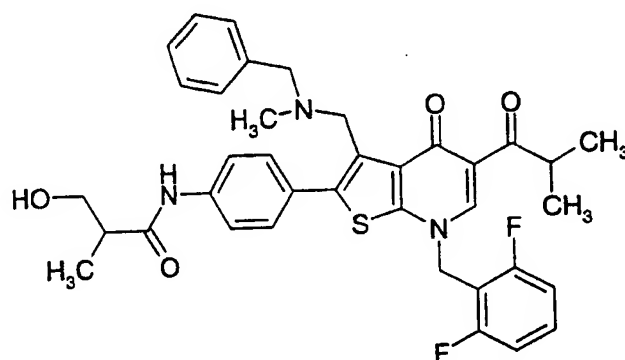


To a solution of the compound obtained in Reference Example 29 (1.14 g, 2.0 mmol) in dichloromethane (30 ml) were added dropwise triethylamine (500 mg, 5 mmol) and 3-acetoxyisobutyryl chloride (0.5 g, 3 mmol) with ice cooling over 1 minute, followed by further stirring at room temperature for 1 hour. The reaction mixture was partitioned between a saturated aqueous solution of sodium hydrogen carbonate (30 ml) and dichloromethane (30 ml), and then the water layer was again extracted with dichloromethane (10 ml). The combined extracts were washed with saline, and dried (Na<sub>2</sub>SO<sub>4</sub>), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel to yield brown crystals (1.4 g).

<sup>1</sup>H-NMR (300MHz, CDCl<sub>3</sub>) δ: 1.18(6H,d), 1.30(3H,d), 2.08(3H,s), 2.12(3H,s), 2.73-2.84(1H,m), 3.65(2H,s), 4.11-4.36(3H,m), 4.17(2H,s), 5.27(2H,s), 7.00(2H,t), 7.13-7.22(5H,m), 7.36-7.46(1H,m), 7.52(1H,br s), 7.62-7.82(4H,q), 8.29(1H, s).

## Example 3

Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-[4-(3-hydroxy-2-methylpropionylamino)phenyl]-4-oxothieno[2,3-b]pyridine



The compound obtained in Example 2 (1.40 g) was dissolved in methanol (100 ml), and then to the solution was added potassium carbonate (2.0 g, 15 mmol), followed by stirring at room temperature for 15 minutes. The reaction mixture was partitioned between ethyl acetate (200 ml) and distilled water (300 ml), and then the water layer was extracted with ethyl acetate (100 ml). The combined extracts were washed with saline, and dried ( $\text{Na}_2\text{SO}_4$ ), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel and recrystallized from ether to yield white crystals (0.95 g, 72%).

mp 161-162 °C.

Elemental analysis for  $\text{C}_{37}\text{H}_{37}\text{N}_3\text{O}_4\text{SF}_2 \cdot 0.5\text{H}_2\text{O}$

	C (%)	H (%)	N (%)
Calculated :	66.65	5.74	6.30
Found :	66.70	5.52	6.40

$^1\text{H-NMR}$  (300MHz,  $\text{CDCl}_3$ )  $\delta$ : 1.17(6H,d), 1.18(3H,d), 2.06(3H,s), 2.67-2.78(1H,m), 3.61(2H,s), 3.57-3.84(2H,m),

3.99-4.08(1H,m), 4.15(2H,s), 5.52(2H,s), 7.08(2H,t),  
7.15(5H,s), 7.44-7.54(1H,m), 7.58(2H,d), 7.69(2H,d),  
8.46(1H, s).

FAB-Mass  $m/z$  658(MH)<sup>+</sup>

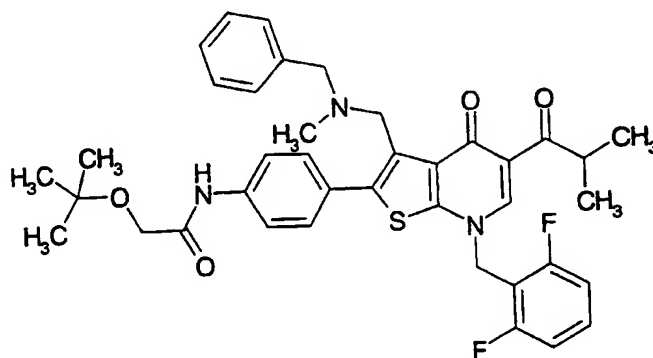
5

### Example 4

Example 4

Using the compound obtained in Reference Example 29, the following compounds (Examples 4-1 to 4-3) were obtained in the same manner as in Example 1.

10      Example 4-1:

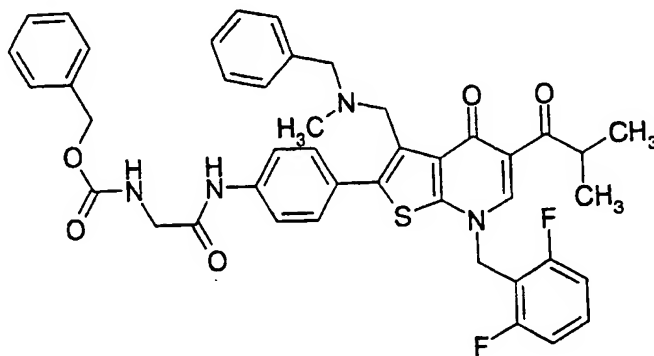


Yield: 67%

mp 201-203 °C.

15

Example 4-2:

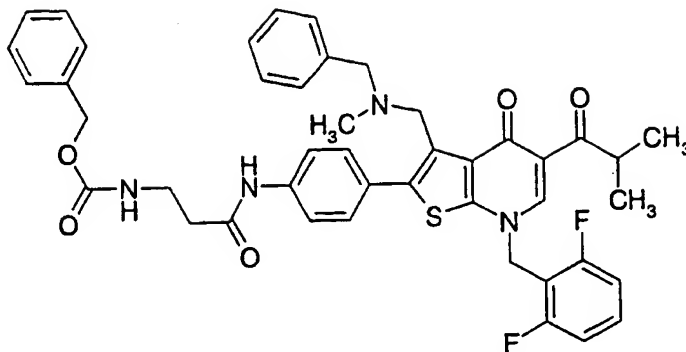


Yield: 58%

20 mp 135-137 °C.



## Example 4-3:

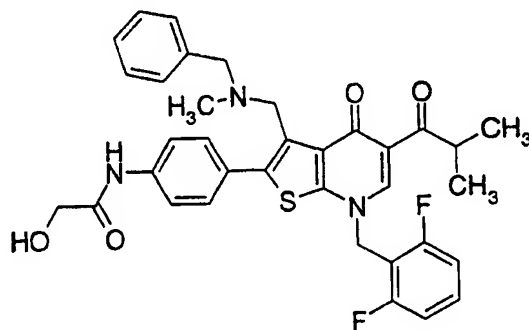


5 Yield: 75%  
mp 205-207 °C.

## Example 5

## Example 5-1:

10 Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-7-(2,6-difluorobenzyl)-2-[4-(2-hydroxyacetylamino)phenyl]-5-isobutyryl-4-oxothieno[2,3-b]pyridine



15

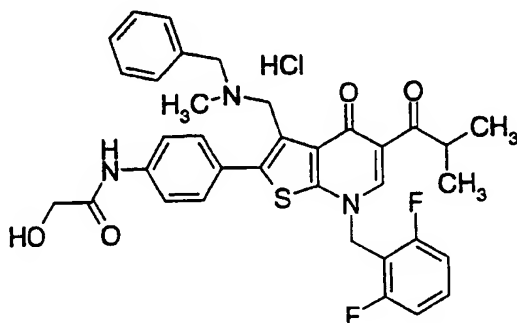
The compound obtained in Example 4-1 (0.137 g) was dissolved in dichloromethane (1.0 ml), and then to the solution was added dropwise trifluoroacetic acid (1.0 ml) with ice cooling. After stirring under ice cooling conditions for 1 hour, the reaction mixture was concentrated

20

to dryness under reduced pressure, and then the obtained residue was partitioned between chloroform (50 ml) and saturated aqueous sodium bicarbonate (50 ml), and then the water layer was again extracted with chloroform (10 ml). The combined organic layers were washed with saturated saline (30 ml). After the organic layer was dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure, and then the obtained residue was chromatographed on silica gel and recrystallized from ethanol-ethyl acetate-ethyl ether to yield white crystalline powders (0.12g, 95%).

Example 5-2:

Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-7-(2,6-difluorobenzyl)-2-[4-(2-hydroxyacetylamino)phenyl]-5-isobutyryl-4-oxothieno[2,3-b]pyridine hydrochloride



The white crystalline powders obtained in Example 5-1 were dissolved in dichloromethane (1.0 ml), and then to this solution was added an ethanolic solution containing 10 N hydrogen chloride (1.0 ml) with ice cooling. The solvent was distilled off under reduced pressure, and then the residue was recrystallized from ethanol-ethyl acetate to yield white crystalline powders (0.12 g, 84%).

mp 197-199 °C.

Elemental analysis for  $\text{C}_{35}\text{H}_{33}\text{N}_3\text{O}_4\text{SF}_2 \cdot \text{HCl} \cdot 2.5\text{H}_2\text{O}$

65

C (%) H (%) N (%)

Calculated : 59.11 ; 5.53 ; 5.91

Found : 59.06 ; 5.25 ; 5.93

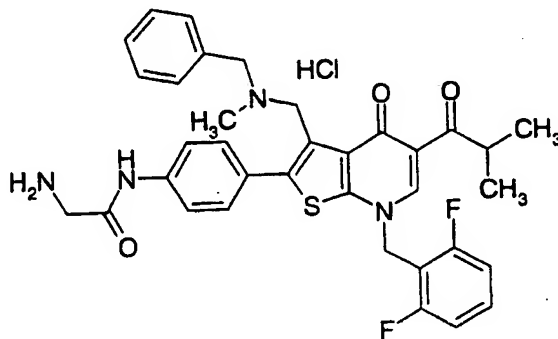
<sup>1</sup>H-NMR (300MHz, CDCl<sub>3</sub>) δ: 1.18(6H, d), 2.10(3H, s),  
5 3.63(2H, s), 3.72(1H, br), 4.09-4.17(1H, m), 4.16(2H, s),  
4.24(2H, s), 5.24(2H, s), 6.99(2H, t), 7.18-7.23(5H, m),  
7.35-7.45(1H, m), 7.63(2H, d), 7.73(2H, d), 8.25(1H, s),  
8.59(1H, s).

## 10 Example 6

Using the compounds obtained in Example 4-2 and Example 4-3, the following compounds (Examples 6-1 to 6-2) were obtained in the same manner as in Example 5.

Example 6-1:

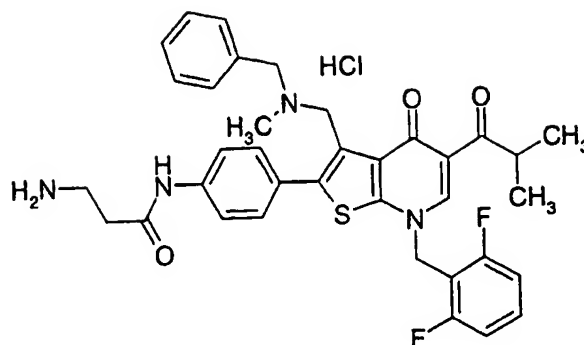
15



Yield: 76%

mp 192-194 °C.

## 20 Example 6-2:



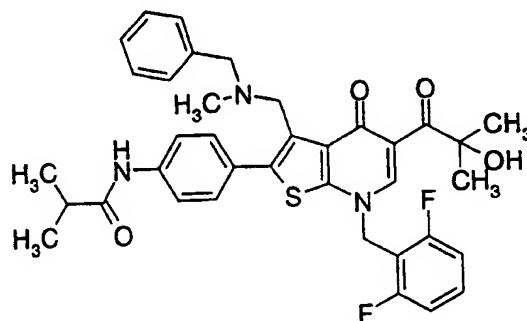
Yield: 81%

mp 193-195 °C.

# 5 Example 7

Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-7-(2,6-difluorobenzyl)-2-(4-isobutyrylamino-phenyl)-5-(2-hydroxy-2-methylpropionyl)-4-oxothieno[2,3-b]pyridine

10



The brown amorphous crystal (0.13 g) obtained by repeating the method described in Reference Example 33 using the compound obtained in Reference Example 31-10 was hydrolyzed with potassium acetate by the same method as described in Reference Example 34. The solid obtained was chromatographed on silica gel to remove the compound obtained in Reference Example 34, and the byproduct was recrystallized from methanol to yield colorless crystalline powders (0.03 g).

mp 170-172 °C.

Elemental analysis for  $C_{37}H_{37}N_3O_4SF_2 \cdot 1/6H_2O$

C (%) H (%) N (%)

Calculated : 67.26 ; 5.69 ; 6.36

5 Found : 67.18 ; 5.74 ; 6.46

$^1H$ -NMR (300MHz,  $CDCl_3$ )  $\delta$ : 1.28(6H,d), 1.49(6H,s),

2.06(3H,s), 2.51-2.60(1H,m), 3.61(2H,s), 4.13(2H,s),

5.31(2H,s), 7.01(2H,t), 7.12-7.21(5H,m), 7.37-7.47(2H,m),

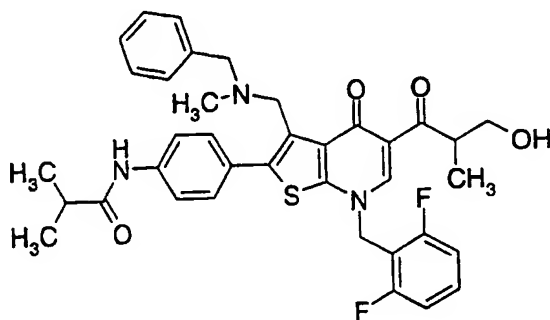
7.64(2H,d), 7.74(2H,d), 8.04(1H,s), 8.35(1H,s).

10 IR (KBr) : 3466, 1669, 1499, 1313, 1075  $cm^{-1}$ .

#### Example 8

Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-7-(2,6-difluorobenzyl)-2-(4-isobutyrylamino-phenyl)-5-(3-hydroxy-2-methylpropionyl)-4-oxothieno[2,3-b]pyridine

15



20 The compound obtained in Reference Example 34 (0.56 g) was dissolved in trifluoroacetic acid (10 ml) and stirred at room temperature for 1 hour. The reaction mixture was concentrated to dryness under reduced pressure, and the obtained residue was partitioned between dichloromethane (30

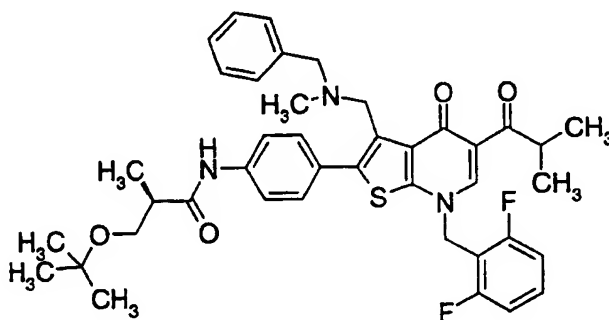
25 ml) and saturated aqueous sodium bicarbonate (60 ml), and then the water layer was again extracted with dichloromethane (10 ml). The combined organic layers were washed with saturated

saline (30 ml). After the organic layer was dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure to yield brown amorphous crystals (0.42 g), which was chromatographed on silica gel to yield yellow crystals (0.07g, overall  
5 recovery rate as calculated from the compound obtained in Reference Example 31-10 12%).

$^1\text{H-NMR}$  (300MHz,  $\text{CDCl}_3$ )  $\delta$ : 1.15(3H, d), 1.26(6H, d), 2.07(3H, s), 2.53-2.62(1H, m), 3.58(2H, d), 3.66(2H, d), 3.82(1H, dd), 3.93(1H, dd), 4.03(1H, d), 4.22(1H, d), 4.27-4.37(1H, m),  
10 5.26(2H, s), 6.99(2H, t), 7.13-7.21(5H, m), 7.36-7.46(1H, m), 7.63(2H, d), 7.67(2H, d), 7.79(1H, s), 8.30(1H, s).

#### Example 9

Production of (R)-4,7-dihydro-2-[4-(3-t-butoxy-2-methylpropionylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-b]pyridine  
15



20

To a solution of the compound obtained in Reference Example 29 (1.14 g, 2.0 mmol) in dichloromethane (20 ml) were added diisopropylethylamine (520 mg, 4 mmol) and (2R)-3-t-butoxy-2-methylpropanoic acid (0.43 g, 3 mmol), followed  
25 by stirring with ice cooling. To this solution was added benzotriazol-1-yloxytrisdimethylaminophosphonium hexafluorophosphate (BOP reagent) (1.33 g, 3 mmol). After stirring with ice cooling for 1 hour, the solution was further

stirred at room temperature for 4 hours. The reaction mixture was concentrated to dryness under reduced pressure, and then the obtained residue was partitioned between water (50 ml) and chloroform (50 ml). The water layer was again extracted with chloroform (10 ml). The combined extracts were washed with saline, and dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel to yield yellow powders (1.11g, 78%).

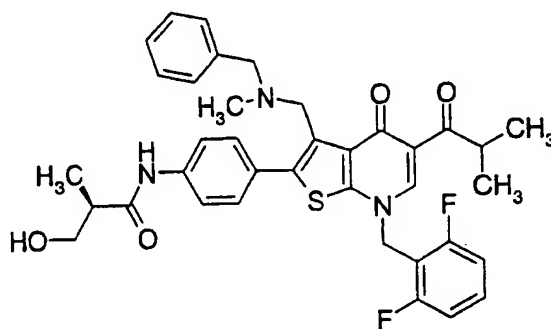
$^1\text{H-NMR}$  (300MHz,  $\text{CDCl}_3$ )  $\delta$ : 1.18(6H,d), 1.25(3H,d), 1.30(9H,s), 2.62(3H,s), 2.63-2.71(1H,m), 3.51(1H,t like), 3.61(1H,dd), 3.64(2H,s), 4.18(2H,s), 4.18(1H,quint), 5.27(2H,s), 7.00(2H,t), 7.14-7.22(5H,m), 7.36-7.46(1H,m), 7.60(2H,d), 7.76(2H,d), 8.28(1H, s), 9.00(1H,s).

15

## Example 10

## Example 10-1:

Production of (R)-4,7-dihydro-2-[4-(3-hydroxy-2-methylpropionylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-b]pyridine



25

The compound obtained in Example 9 (1.11 g) was dissolved in trifluoroacetic acid (5 ml) under ice cooling conditions, and then after stirring for 1 hour, the solution was allowed to warm to room temperature and stirred for further 12 hours.

The reaction mixture was concentrated to dryness under reduced pressure, and then the residue was dissolved in methanol (20 ml) and again cooled with ice, and then a 5 N solution of sodium hydroxide was added to reach pH 9.0. The reaction mixture was stirred for 30 minutes and further stirred at room temperature for 30 minutes. The reaction mixture was concentrated to dryness under reduced pressure at low temperature, and then the obtained residue was chromatographed on silica gel. The light yellow amorphous crystals obtained (0.83 g, 82%) were recrystallized from ether to yield light yellow powdery crystals (0.69 g). mp 161-162 °C.

Elemental analysis for  $C_{37}H_{37}N_3O_4SF_2 \cdot 0.5H_2O$

C (%) H (%) N (%)

Calculated : 66.65 ; 5.74 ; 6.30

Found : 66.47 ; 5.73 ; 6.10

$^1H$ -NMR (300MHz,  $CDCl_3$ )  $\delta$ : 1.18(6H,d), 1.28(3H,d),

2.11(3H,s), 2.71(1H,m), 3.65(2H,s), 3.83-3.85(2H,m),

4.16(1H,quint), 4.18(2H,s), 5.27(2H,s), 7.00(2H,t), 7.14-

7.23(5H,m), 7.36-7.44(1H,m), 7.64(2H,d), 7.77(2H,d),

8.09(1H, s), 8.28(1H,s).

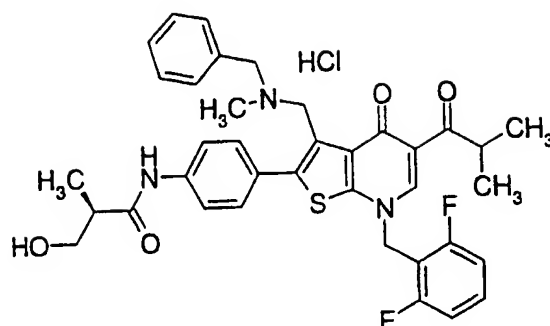
FAB-Mass m/z 658(MH)<sup>+</sup>

#### Example 10-2:

Production of (R)-4,7-dihydro-2-[4-(3-hydroxy-2-methylpropionylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-b]pyridine hydrochloride



71



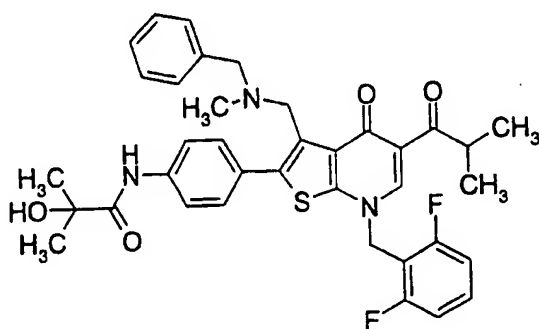
The title compound was obtained in the same manner as  
in Example 1.

5 mp 214-216 °C.

#### Example 11

##### Example 11-1:

10 Production of 4,7-dihydro-2-[4-(2-hydroxy-2-  
methylpropionylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-  
benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-  
b]pyridine



15

To a solution of the compound obtained in Reference  
Example 29 (1.14 g, 2.0 mmol) in dichloromethane (30 ml) were  
added diisopropylethylamine (1.04 g, 8 mmol) and 2-  
hydroxyisobutanoic acid (0.416 g, 4 mmol), followed by  
20 stirring under ice cooling conditions. To this solution was  
added benzotriazol-1-yloxytrisdimethylaminophosphonium  
hexafluorophosphate (BOP reagent) (1.76 g, 4 mmol). After

stirring under ice cooling conditions for 1 hour, the solution was further stirred at room temperature for 4 days. The reaction mixture was concentrated to dryness under reduced pressure, and then the obtained residue was partitioned  
5 between water (50 ml) and chloroform (50 ml). The water layer was again extracted with chloroform (10 ml). The combined extracts were washed with saline, and dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure. The  
10 obtained residue was chromatographed on silica gel and recrystallized from ether to yield yellow powdery crystals (0.56 g, 43%).

mp 178-180 °C.

Elemental analysis for  $\text{C}_{37}\text{H}_{37}\text{N}_3\text{O}_4\text{SF}_2 \cdot 0.5\text{H}_2\text{O}$

C (%) H (%) N (%)

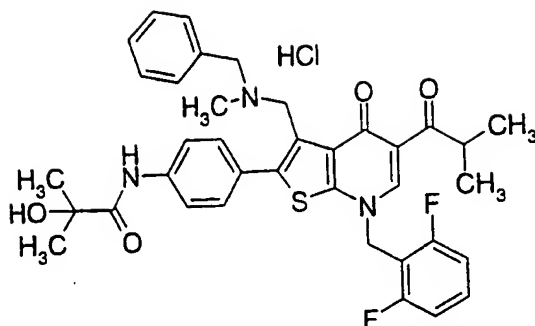
15 Calculated : 66.65 ; 5.74 ; 6.30

Found : 66.54 ; 5.49 ; 6.36

$^1\text{H-NMR}$  (300MHz,  $\text{CDCl}_3$ )  $\delta$ : 1.18(6H,d), 1.58(6H,s),  
2.10(3H,s), 3.05(1H,brs), 3.64(2H,s), 4.16(2H,s), 4.12-  
4.22(1H,m), 5.23(2H,s), 6.99(2H,t), 7.05-7.25(5H,m),  
20 7.34-7.44(1H,m), 7.64(2H,d), 7.75(2H,d), 8.25(1H, s),  
8.86(1H, s).

Example 11-2:

Production of 4,7-dihydro-2-[4-(2-hydroxy-2-  
25 methylpropionylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-  
benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-  
b]pyridine hydrochloride



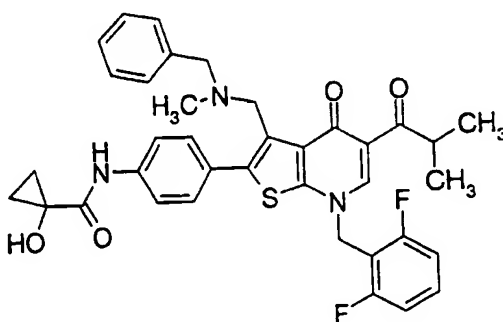
The title compound was obtained in the same manner as  
in Example 1.

5 mp 213-215 °C.

#### Example 12

##### Example 12-1:

10 Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-  
dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-[4-[(1-  
hydroxycyclopropyl)carbonylamino]phenyl]-4-oxothieno[2,3-  
b]pyridine



15

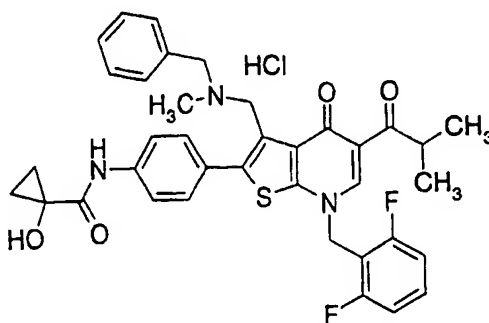
To a solution of the compound obtained in Reference  
Example 29 (0.57 g, 1.0 mmol) in dichloromethane (10 ml) were  
added diisopropylethylamine (0.52 g, 4 mmol) and 2-  
hydroxycyclopropanecarboxylic acid (0.204 g, 2 mmol),  
20 followed by stirring under ice cooling conditions. To this  
solution was added benzotriazol-1-  
yloxytrisdimethylaminophosphonium hexafluorophosphate (BOP

reagent) (1.76 g, 4 mmol). After stirring under ice cooling conditions for 1 hour, the solution was further stirred at room temperature for 4 days. The reaction mixture was concentrated to dryness under reduced pressure, and then the obtained residue was partitioned between water (50 ml) and chloroform (50 ml). The water layer was again extracted with chloroform (10 ml). The combined extracts were washed with saline, and dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel and recrystallized from ether to yield yellow powdery crystals (0.27 g, 41%).

$^1\text{H-NMR}$  (300MHz,  $\text{CDCl}_3$ )  $\delta$ : 1.16-1.20(2H,m), 1.18(6H,d), 1.48-1.51(2H,m), 2.09(3H,s), 3.64(2H,s), 3.95(1H,br s), 4.14(2H,s), 4.12-4.19(1H,m), 5.20(2H,s), 6.99(2H,t), 7.10-7.25(5H,m), 7.34-7.46(1H,m), 7.57(2H,d), 7.70(2H,d), 8.21(1H, s), 8.82(1H, s).

#### Example 12-2:

Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-[4-[(1-hydroxycyclopropyl)carbonylamino]phenyl]-4-oxothieno[2,3-b]pyridine hydrochloride



25

The title compound, white powdery crystals (0.12g) was obtained in the same manner as in Example 1.  
Solvent for recrystallization: ethanol-ether

mp 220-222 °C.

Elemental analysis for  $C_{37}H_{35}N_3O_4SF_2 \cdot HCl \cdot 0.5H_2O$

C (%) H (%) N (%)

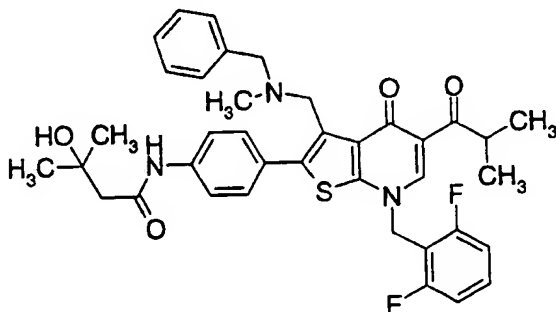
Calculated : 63.37 ; 5.32 ; 5.99

5 Found : 63.35 ; 5.24 ; 5.82

### Example 13

#### Example 13-1:

10 Production of 4,7-dihydro-2-[4-(3-hydroxy-3-methylbutyrylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-b]pyridine



15

To a solution of the compound obtained in Reference Example 29 (1.14 g, 2.0 mmol) in dichloromethane (10 ml) were added diisopropylethylamine (1.04 g, 8 mmol) and 3-hydroxy-3-methylbutanoic acid (0.47 g, 4 mmol), followed by stirring under ice cooling conditions. To this solution was added benzotriazol-1-yloxytrisdimethylaminophosphonium hexafluorophosphate (BOP reagent) (1.76 g, 4 mmol). After stirring under ice cooling conditions for 1 hour, the solution was further stirred at room temperature for 4 days. The reaction mixture was concentrated to dryness under reduced pressure, and then the obtained residue was partitioned between water (50 ml) and chloroform (50 ml). The water layer was again extracted with chloroform (10 ml). The combined

20

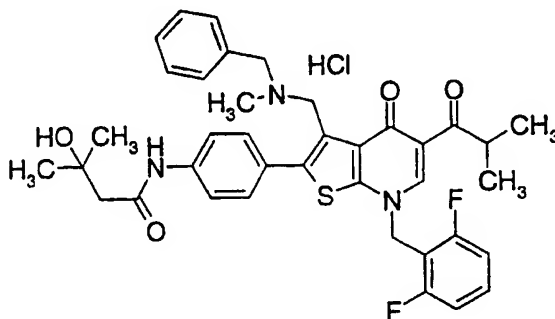
25

extracts were washed with saline, and dried ( $\text{MgSO}_4$ ), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel and recrystallized from ether to yield yellow powdery crystals (0.50 g, 37%).

$^1\text{H-NMR}$  (300MHz,  $\text{CDCl}_3$ )  $\delta$ : 1.17(6H,d), 1.39(6H,s), 2.11(3H,s), 2.58(2H,s), 3.12(1H, br s), 3.65(2H,s), 4.12-4.19(1H,m), 4.18(2H,s), 5.27(2H,s), 7.00(2H,t), 7.10-7.23(5H,m), 7.32-7.44(1H,m), 7.61(2H,d), 7.79(2H,d), 8.24(1H, s), 8.28(1H, s).

#### Example 13-2:

Production of 4,7-dihydro-2-[4-(3-hydroxy-3-methylbutyrylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-b]pyridine hydrochloride



The title compound, white powdery crystals (0.42g) were obtained in the same manner as in Example 1. Solvent for recrystallization: ethanol

mp 216-218 °C.

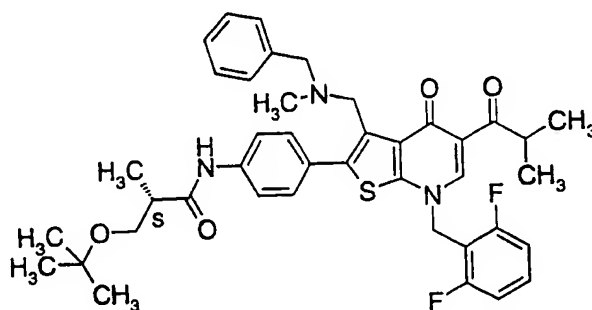
Elemental analysis for  $\text{C}_{38}\text{H}_{39}\text{N}_3\text{O}_4\text{SF}_2 \cdot \text{HCl} \cdot \text{H}_2\text{O}$

	C (%)	H (%)	N (%)
Calculated :	62.84	5.83	5.79
Found :	62.70	5.75	5.82

## Example 14

The following compounds (Examples 14-1 through 14-10) were produced by the same method as described in Examples 9, 11, 12, and 13, using the compound obtained in Reference Example 29, and also using various carboxylic acid compounds in place of, for example, (2R)-3-t-butoxy-2-methylpropanoic acid, which was used in Example 9.

## Example 14-1:



Yield: 46%

Amorphous.

 $^1\text{H-NMR}$  (300MHz,  $\text{CDCl}_3$ )  $\delta$ : 1.18(6H,d), 1.25(3H,d),

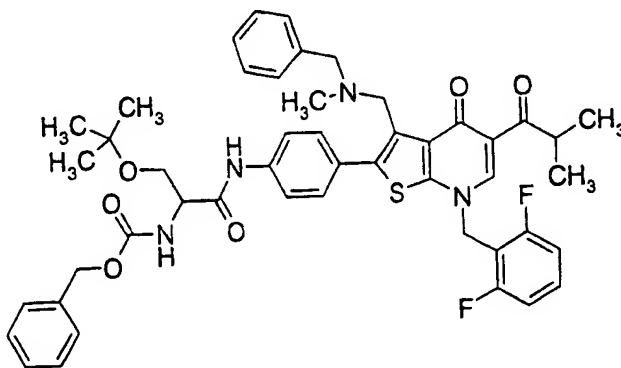
1.30(9H,s), 2.11(3H,s), 2.60(1H,br), 3.51(1H, t like),

3.59-3.65(1H,m), 3.65(2H,s), 4.17(1H,q), 4.18(2H,s),

5.27(2H,s), 7.00(2H,t), 7.12-7.22(5H,m), 7.38-7.44(1H,m),

7.60(2H,d), 7.75(2H,d), 8.28(1H, s), 9.00(1H, s).

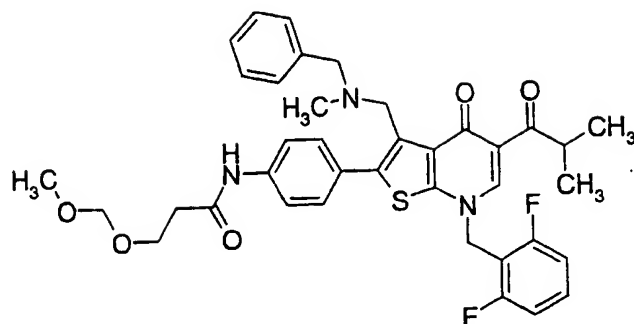
## Example 14-2:



Yield: 47%

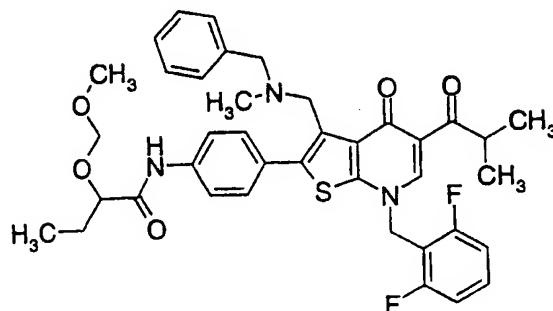
mp 145-150 °C.

Example 14-3:



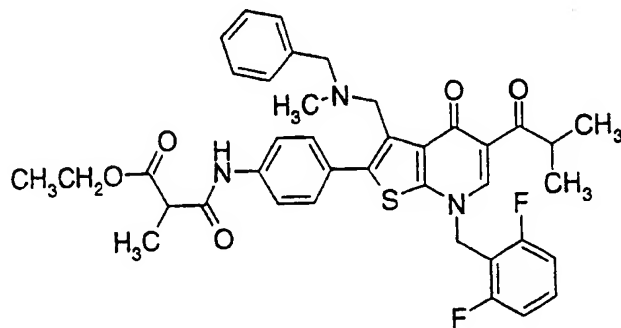
5 Yield: 99%  
mp 96-98 °C.

Example 14-4:



10 Yield: 57%  
mp 92-94 °C.

Example 14-5:



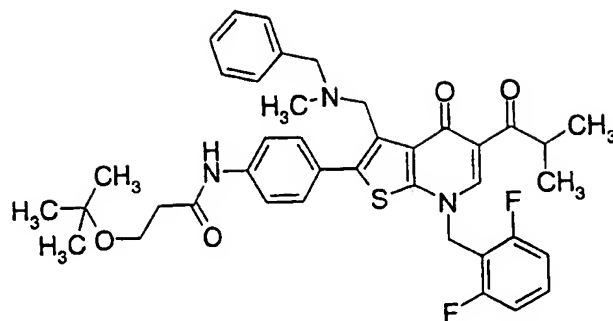


79

Yield: 71%

mp 57-62 °C.

Example 14-6:

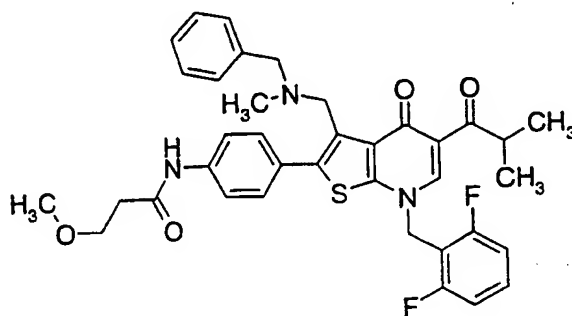


5

Yield: 92%

mp 79-81 °C.

Example 14-7:

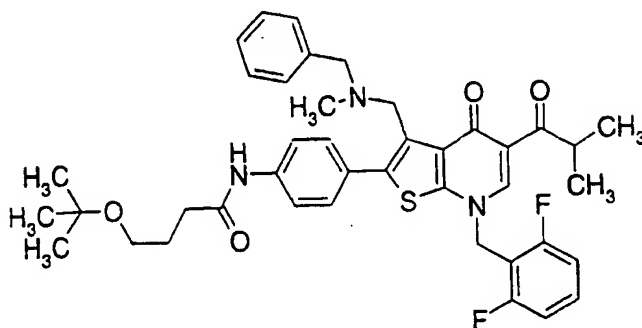


10

Yield: 97%

mp 91-96 °C.

Example 14-8:

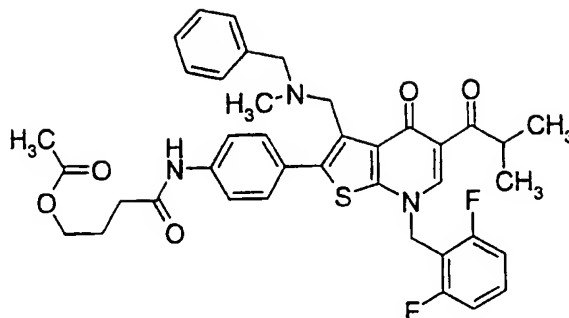


15

Yield: 91%

mp 75-80 °C.

Example 14-9:

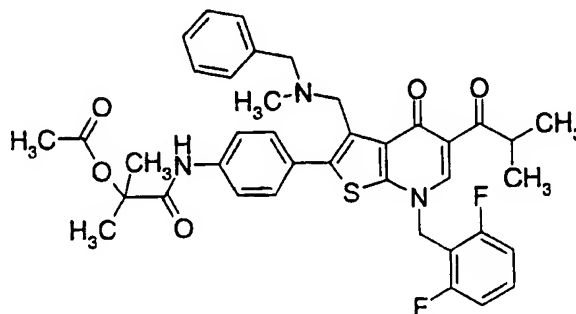


5

Yield: 87%

mp 83-88 °C.

Example 14-10:



10

Yield: 50%

mp 130-135 °C.

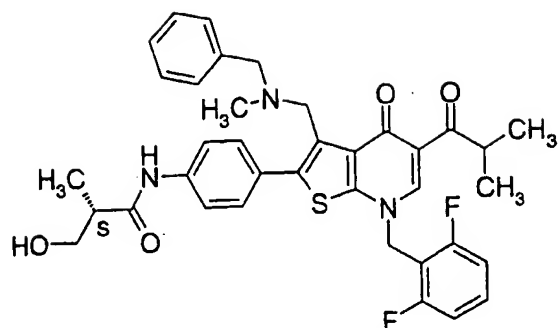
Example 15

15

Using the compound obtained in Example 14, the following compounds (Examples 15-1 to 15-6) in the same manner as in Example 10.

Example 15-1:

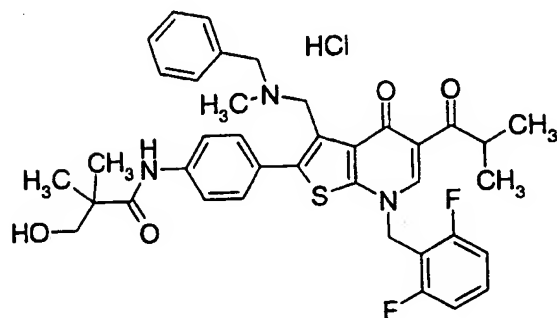
81



Yield: 69%

mp 161-162 °C.

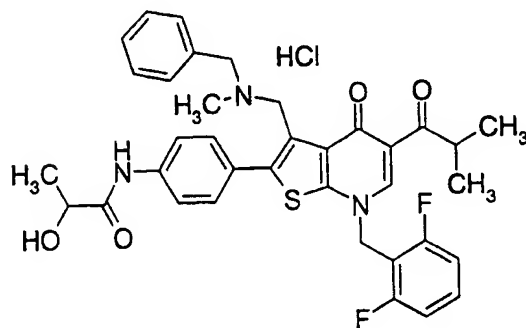
## 5 Example 15-2:



Yield: 94%

mp 153-155 °C.

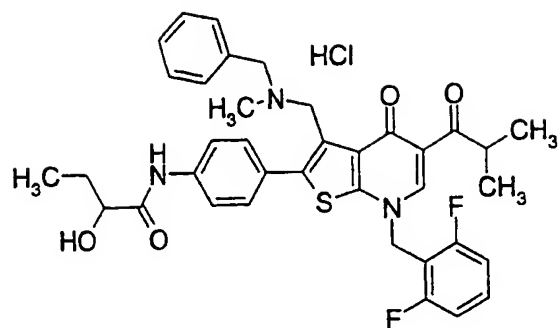
## 10 Example 15-3:



Yield: 62%

mp 224-226 °C.

## Example 15-4:

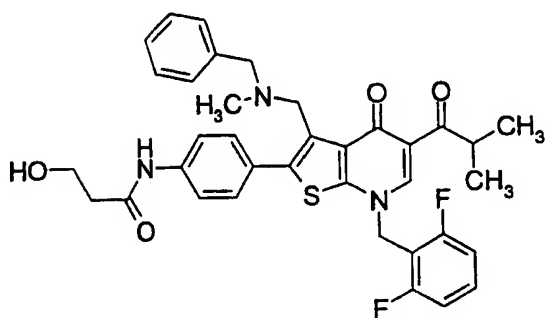


Yield: 56%

mp 230-232 °C.

5

## Example 15-5:

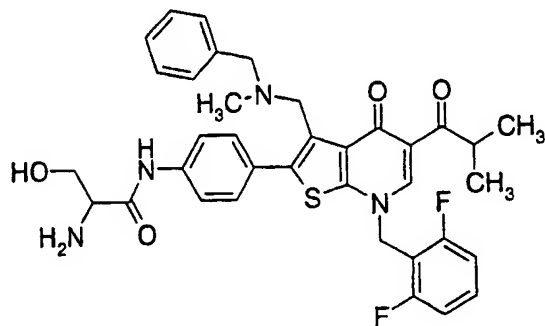


Yield: 90%

mp 92-94 °C.

10

## Example 15-6:



Yield: 34%

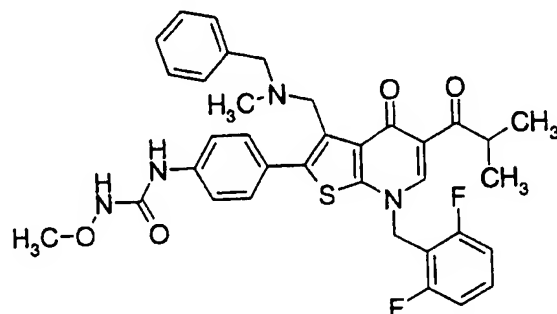
mp 107-112 °C.

15

## Example 16

## Example 16-1:

Production of 3-(N-benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-(4-N'-methoxyureidophenyl)-4-oxothieno[2,3-b]pyridine



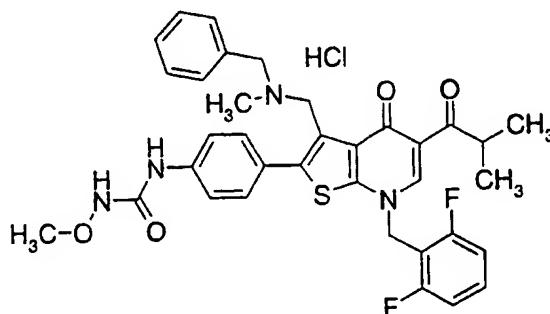
To a solution of the compound obtained in Reference Example 29 (0.40 g, 0.7 mmol) in dichloromethane (15 ml) were added triethylamine (0.20 ml, 1.43 mmol) and N,N'-carbonyldiimidazole (0.228 g, 1.41 mmol), followed by stirring under ice cooling conditions. After the solution was allowed to warm to room temperature and further stirred for 2.5 days, to the mixture were added O-methylhydroxylamine hydrochloride (0.59 g, 7.06 mmol) and triethylamine (0.98 ml, 7.03 mmol) with ice cooling. While the solution was allowed to return to room temperature, it was stirred for 1.5 hours. After dilution with water (50 ml), the reaction mixture was extracted with chloroform (50 ml). The water layer was again extracted with chloroform (10 ml). The combined extracts were washed with saline, and dried (MgSO<sub>4</sub>), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel to yield yellow amorphous powders (0.349 g, 77%).

<sup>1</sup>H-NMR (300MHz, CDCl<sub>3</sub>) δ: 1.19(6H,d), 2.17(3H,s), 3.72(2H,brs), 3.83(3H,s), 4.10-4.20(1H,m), 4.22(2H,brs), 5.28(2H,s), 7.00(2H,t), 7.15-7.24(5H,m), 7.37-7.46(2H,m),

7.59(2H,d), 7.75(2H,d), 7.83(1H, br), 8.31(1H,s).

Example 16-2:

Production of 4,7-dihydro-2-(4-N'-  
5 methoxyureidophenyl)-7-(2,6-difluorobenzyl)-3-(N-benzyl-  
N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-  
b]pyridine hydrochloride



10

The title compound, white amorphous powders (0.335 g)  
were obtained in the same manner as in Example 1.  
Solvent for recrystallization: ethyl acetate-ether  
mp 225-230 °C.

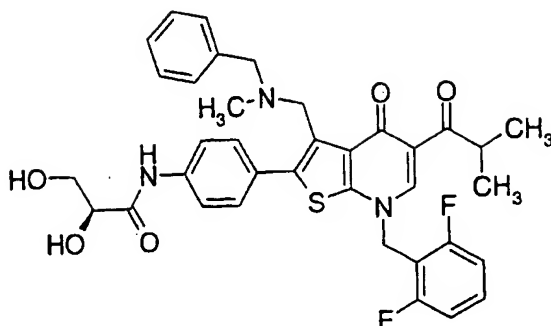
15 Elemental analysis for  $C_{35}H_{34}N_4O_4SF_2 \cdot HCl \cdot 0.5H_2O$

	C (%)	H (%)	N (%)
Calculated :	60.91	5.26	8.12
Found :	60.80	5.07	8.17

20 Example 17

Example 17-1:

Production of (R)-4,7-dihydro-2-[4-(2,3-  
dihydroxypropionylamino)phenyl]-7-(2,6-difluorobenzyl)-3-  
(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-  
25 oxothieno[2,3-b]pyridine



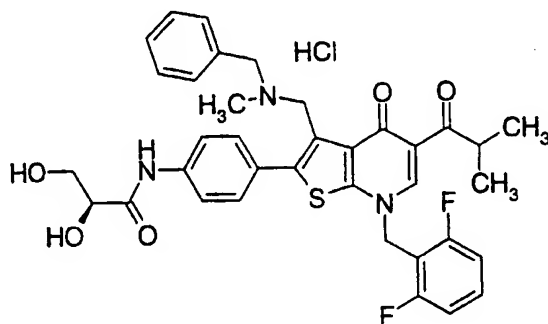
To a 2 N aqueous solution of potassium hydroxide was added (R)-(+)-2,2-dimethyl-1,3-dioxolan-4-carboxylic acid methyl ester (1.00 g, 6.24 mmol), followed by stirring under ice cooling conditions for 3 hours. After neutralization with hydrochloric acid, the solution was salted out and extracted with ethyl acetate (50 ml) to yield (R)-(+)-2,2-dimethyl-1,3-dioxolan-4-carboxylic acid as colorless amorphous powders (0.72 g). To a solution of the compound obtained in Reference Example 29 (0.572 g, 1.0 mmol) in dichloromethane (5 ml) were added diisopropylethylamine (1.04 g, 8 mmol) and the (R)-(+)-2,2-dimethyl-1,3-dioxo-  
lane-4-carboxylic acid obtained (0.292 g, 2 mmol), followed by stirring under ice cooling conditions. To this solution was added benzotriazol-1-yloxytrisdimethylaminophosphonium hexafluorophosphate (BOP reagent) (0.885 g, 2 mmol). After stirring under ice cooling conditions for 1 hour, the solution was further stirred at room temperature for 4 days. The reaction mixture was concentrated to dryness under reduced pressure, and then the obtained residue was partitioned between water (50 ml) and chloroform (50 ml). The water layer was again extracted with chloroform (10 ml). The combined extracts were washed with saline, and dried (MgSO<sub>4</sub>), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel to yield colorless amorphous powders (0.5 g), which was then dissolved in trifluoroacetic acid (10 ml) and stirred at room

temperature for 16 hours. The reaction mixture was concentrated to dryness under reduced pressure and treated with alkali, after which it was partitioned between chloroform (50 ml) and water (50 ml), and then the water layer was again extracted with chloroform (10 ml). The combined extracts were washed with saline, and dried (MgSO<sub>4</sub>), the solvent was distilled off under reduced pressure. The obtained residue was chromatographed on silica gel to yield 0.5 g of colorless amorphous powders (76%).

<sup>1</sup>H-NMR (300MHz, DMSO-d<sub>6</sub>) δ: 1.09(6H,d), 1.95(3H,s), 3.51(2H,br), 3.55-3.72(2H,m), 4.01-4.08(4H,m), 4.84(1H,t), 5.63(2H,brs), 5.80(1H,d), 7.15-7.24(7H,m), 7.49-7.57(1H,m), 7.66(2H,d), 7.84(2H,d), 8.53(1H,s), 9.82(1H,s).

#### Example 17-2:

Production of (R)-4,7-dihydro-2-[4-(2,3-dihydroxypropionylamino)phenyl]-7-(2,6-difluorobenzyl)-3-(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-b]pyridine hydrochloride



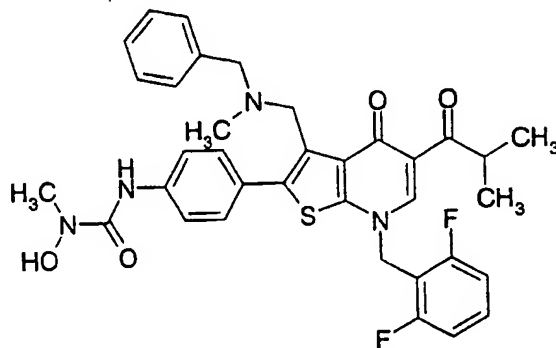
The title compound, white powdery crystals (0.43 g) were obtained in the same manner as in Example 1.

Solvent for recrystallization: ether-ethanol  
mp 146-148 °C.



## Example 18

Production of 4,7-dihydro-2-(4-N'-hydroxy-N'-methylureidophenyl)-7-(2,6-difluorobenzyl)-3-(N-benzyl-N-methylaminomethyl)-5-isobutyryl-4-oxothieno[2,3-b]pyridine



To a solution of the compound obtained in Reference Example 29 (1.0 g, 1.75 mmol) in dichloromethane (40 ml) were added triethylamine (0.49 ml, 3.50 mmol) and N,N'-carbonyldiimidazole (0.567 mg, 3.50 mmol), followed by stirring under ice cooling conditions. After the solution was allowed to warm to room temperature and further stirred for 17 hours, to the mixture was added N-methylhydroxylammonium chloride (730 mg, 8.75 mmol) and triethylamine (1.23 ml, 8.75 mmol) with ice cooling. While the solution was allowed to warm to room temperature, it was stirred for 5 hours. The reaction mixture was partitioned between chloroform (300 ml) and aqueous sodium bicarbonate (saturated, 200 ml), and then the organic layer was again washed with saline (200 ml). After the organic layer was dried (MgSO<sub>4</sub>), the solvent was distilled off under reduced pressure. The residue obtained was chromatographed on silica gel to yield pale yellow amorphous powder (0.38 g, 34%).

<sup>1</sup>H-NMR (300MHz, CDCl<sub>3</sub>) δ: 1.18( 6H, d), 2.15( 3H, s), 3.26(3H, s), 3.71(2H, s), 4.19(2H, s), 5.25(2H, s), 7.00(2H, t),

88

7.22-7.26( 5H, m), 7.41( 1H, m), 7.49( 2H,d), 7.60( 2H,d),  
8.06( 1H, s), 8.26( 1H, s).

Elemental analysis for  $C_{35}H_{34}N_4O_4SF_2 \cdot 0.8H_2O$

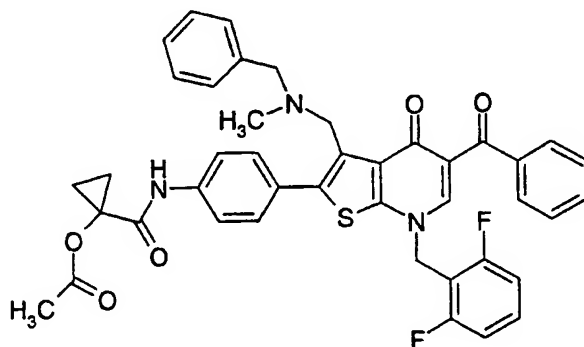
C (%) H (%) N (%)

5 Calculated : 63.78 ; 5.44 ; 8.50

Found : 63.73 ; 5.24 ; 8.41

### Example 19

10 Production of 2-[4-[(1-acetoxycyclopropyl)carbonylamino]phenyl]-3-(N-benzyl-N-methylaminomethyl)-5-benzoyl-7-(2,6-difluorobenzyl)-4,7-dihydro-4-oxothieno[2,3-b]pyridine



15

To a solution of the compound obtained in Reference Example 28 (0.42 g, 0.7 mmol) and triethylamine (0.08 g, 0.8 mmol) in dichloromethane (10 ml) was added 1-acetoxycyclopropanecarbonyl chloride (0.13 g, 0.8 mmol) with  
20 ice-cooling. The mixture was stirred at 0 °C for 30 minutes and at room temperature for 30 minutes. The reaction mixture was diluted with chloroform (20 ml) and the solution was washed with aqueous sodium bicarbonate (saturated, 20 ml), and brine (20 ml). After the organic layer was dried ( $Na_2SO_4$ ),  
25 the solvent was distilled off under reduced pressure. The residue obtained was chromatographed on silica gel to yield pale yellow amorphous powders (0.34 g, 66%).

$^1H$ -NMR (300MHz,  $CDCl_3$ )  $\delta$ : 1.22( 2H, dd), 1.68( 2H, dd),

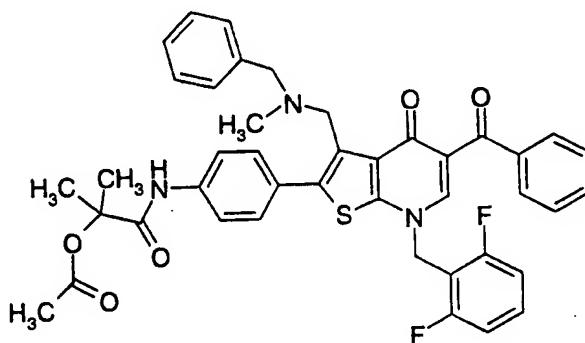
2.12(3H, s), 2.21(3H, s), 3.64(2H, s), 4.13(2H, s), 5.28(2H, s), 7.01( 2H, t), 7.17-7.23( 5H, m), 7.37-7.44( 3H, m), 7.51-7.56( 1H, m), 7.60( 2H, d), 7.81( 2H, d), 7.87-7.90(3H, m), 7.94(1H, s).

5 FAB-Mass m/z 732 (MH)<sup>+</sup>

#### Example 20

Using the compound obtained in Reference Example 28, the following compound Examples 20-1 was obtained in the same manner as in Example 19

#### Example 20-1:



15 Yield : 80%

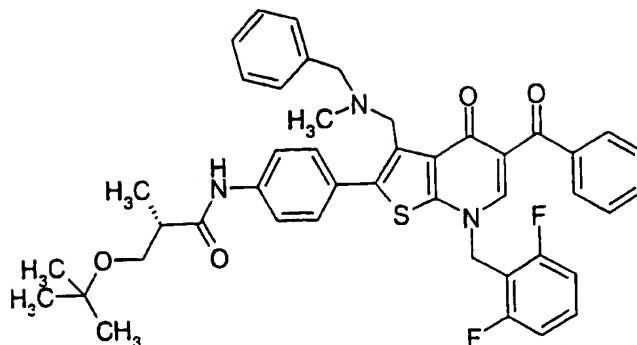
<sup>1</sup>H-NMR (300MHz, CDCl<sub>3</sub>) δ: 1.77(6H, s), 2.12(3H, s), 2.17(3H, s), 3.63(2H, s), 4.13(2H, s), 5.29(2H, s), 7.01(2H, t), 7.15-7.23(5H, m), 7.38-7.45(3H, m), 7.51-7.56(1H, m), 7.64(2H, d), 7.85(2H, d), 7.88-7.90(3H, m), 7.94(1H, s).

20 FAB-Mass m/z 734(MH)<sup>+</sup>

Using the compound obtained in Reference Example 28, the following compound Examples 20-2 was obtained in the same manner as in Example 19

25 Example 20-2:

90



Yield: 84%

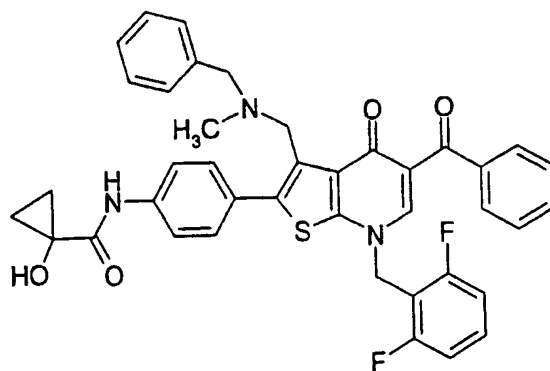
$^1\text{H-NMR}$  (300MHz,  $\text{CDCl}_3$ )  $\delta$ : 1.25(3H, d), 1.30(9H, s), 2.10(3H, s), 2.65-2.67(1H, br m), 3.51(2H, t), 3.60(2H, s), 4.12(2H, s), 5.28(2H, s), 7.00(2H, t), 7.16-7.23(5H, m), 7.37-7.42 (3H, m), 7.50-7.53(1H, m), 7.61(2H, d), 7.80(2H, d), 7.89(2H, d), 7.94(1H, s), 9.01(1H, s).

FAB-Mass  $m/z$  748(MH)<sup>+</sup>

## 10 Example 21

Production of 3-(N-benzyl-N-methylaminomethyl)-5-benzoyl-7-(2,6-difluorobenzyl)-4,7-dihydro-2-[4-[(1-hydroxycyclopropyl)carbonylamino]phenyl]-4-oxothieno[2,3-b]pyridine

15



A mixture of the compound obtained in Example 19 (0.24 g, 0.33 mmol) and 5N sodium hydroxide (0.07 ml) in ethanol (8 ml) was stirred at room temperature for 1 hour. After the

20

solvent was distilled off under reduced pressure, the residue obtained was dissolved in chloroform (30 ml) and the solution was washed with aqueous sodium bicarbonate (saturated, 20 ml) and brine (20 ml). After the organic layer was dried ( $\text{Na}_2\text{SO}_4$ ), the solvent was distilled off under reduced pressure and the residue obtained was recrystallized from chloroform-ether to yield pale yellow powders (0.17 g, 75%).  
mp 186-188 °C.

$^1\text{H-NMR}$  (300MHz,  $\text{CDCl}_3$ )  $\delta$ : 1.15( 2H, dd), 1.44( 2H, dd), 2.05(3H, s), 3.56(2H, s), 4.01(2H, s), 4.56(1H, br s), 5.24(2H, s), 7.00( 2H, t), 7.14-7.22( 5H, m), 7.41( 3H, t), 7.55( 2H, d), 7.55(1H, s), 7.70( 2H, d), 7.88(2H, d), 7.90(1H, s), 8.88(1H, s).

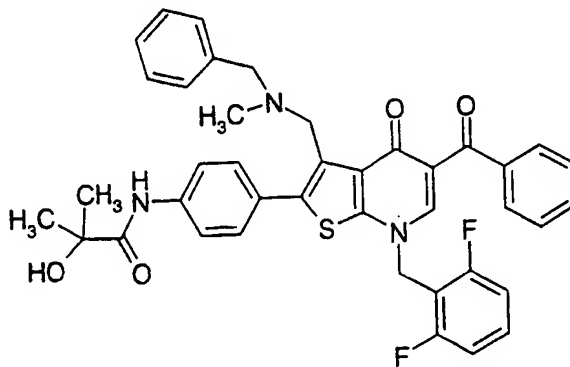
Elemental analysis for  $\text{C}_{40}\text{H}_{33}\text{N}_3\text{O}_4\text{SF}_2 \cdot 1.0\text{H}_2\text{O}$

	C (%)	H (%)	N (%)
Calculated:	67.88	4.98	5.94
Found	67.75	4.70	5.90

FAB-Mass  $m/z$  690 ( $\text{MH}^+$ )

## Example 22

Production of 3-(N-benzyl-N-methylaminomethyl)-5-benzoyl-7-(2,6-difluorobenzyl)-4,7-dihydro-2-[4-(2-hydroxy-2-methylpropionylamino)phenyl]-4-oxothieno[2,3-b]pyridine



Using the compound obtained in Example 20-1, the title

compound was obtained in the same manner as in Example 21.

Solvent for recrystallization: chloroform-ether

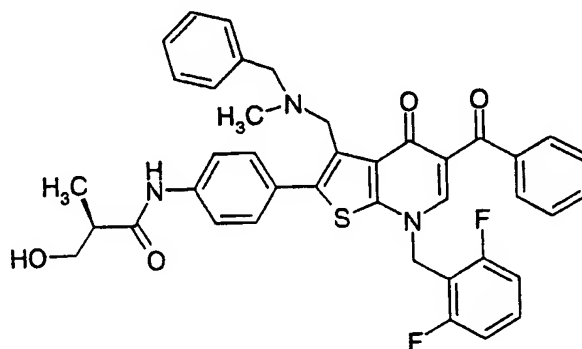
mp 222-223 °C.

<sup>1</sup>H-NMR (300MHz, CDCl<sub>3</sub>) δ: 1.57( 6H, s), 2.09(3H, s), 2.50(1H, s), 3.59(2H, s), 4.10(2H, s), 5.28(2H, s), 7.01(2H, t), 7.16-7.25(5H, m), 7.38-7.44(3H, m), 7.51-7.56(1H, m), 7.67(2H, d), 7.82(2H, d), 7.89(2H, d), 7.93(1H, s), 8.82(1H, s).

FAB-Mass m/z 692 (MH)<sup>+</sup>

### Example 23

Production of (R)-3-(N-benzyl-N-methylaminomethyl)-5-benzoyl-7-(2,6-difluorobenzyl)-4,7-dihydro-2-[4-[(3-hydroxy-2-methylbutyrylamino)phenyl]-4-oxothieno[2,3-b]pyridine



Using the compound obtained in Example 20-2, the title compound was obtained in the same manner as in Example 10.

Solvent for recrystallization: chloroform-ether

mp 145-146 °C.

<sup>1</sup>H-NMR (300MHz, CDCl<sub>3</sub>) δ: 1.25(3H, d), 2.07(3H, s), 2.63-2.70(1H, m), 2.84(1H, br s), 3.57(2H, s), 3.78-3.81(2H, m), 4.08(2H, s), 5.27(2H, s), 7.00(2H, t), 7.17-7.20(5H, m), 7.37-7.43(3H, m), 7.51-7.56(1H, m), 7.61(2H, d), 7.77(2H, d), 7.89(2H, d), 7.94(1H, s), 8.31(1H, br s).

FAB-Mass m/z 692 (MH)<sup>+</sup>

Preparation Example 1

Using 100 mg of the compound produced in Example 1-2,  
5 165 mg of lactose, 25 mg of corn starch, 4 mg of polyvinyl  
alcohol and 1 mg of magnesium stearate, tablets are produced  
by a conventional method.

Preparation Example 2

10 The compound produced in Example 1-2 (5 g) is dissolved  
in distilled water for injection to make a total volume of  
100 ml. This solution is aseptically filtered through a 0.22  
µm membrane filter (produced by Sumitomo Electric Industries,  
Ltd. or Sartorius) and dispensed at 2 ml per washed sterile  
15 vial, followed by freeze-drying by a conventional method, to  
yield a 100 mg/vial freeze-dried injectable preparation.

Preparation Example 3

Using 100 mg of the compound produced in Example 3, 165  
20 mg of lactose, 25 mg of corn starch, 4 mg of polyvinyl alcohol  
and 1 mg of magnesium stearate, tablets are produced by a  
conventional method.

Preparation Example 4

25 The compound produced in Example 3 (5 g) is dissolved  
in distilled water for injection to make a total volume of  
100 ml. This solution is aseptically filtered through a 0.22  
µm membrane filter (produced by Sumitomo Electric Industries,  
Ltd. or Sartorius) and dispensed at 2 ml per washed sterile  
30 vial, followed by freeze-drying by a conventional method, to  
yield a 100 mg/vial freeze-dried injectable preparation.

Preparation Example 5

(1) Compound produced in Example 1-2 5 g  
35 (2) Lactose/crystalline cellulose (particles) 330 g

	(3) D-mannitol	29 g
	(4) Low-substitutional hydroxypropyl cellulose	20 g
	(5) Talc	25 g
	(6) Hydroxypropyl cellulose	50 g
5	(7) Aspartame	3 g
	(8) Dipotassium glycyrrhizinate	3 g
	(9) Hydroxypropylmethyl cellulose 2910	30 g
	(10)Titanium oxide	3.5 g
	(11)Yellow iron sesquioxide	0.5 g
10	(12)Light silicic anhydride	1 g

Components (1), (3), (4), (5), (6), (7) and (8) are suspended or dissolved in purified water and coated on the core particles (2) to yield base fine subtilae, which are then further coated with components (9) through (11) to yield coated fine subtilae, which are then mixed with component (12) to yield 500 g of 1% fine subtilae of the compound. These subtilae are divided to 500 mg folded subtilae.

## 20 Experimental Example 1

### Preparation of $^{125}\text{I}$ -leuprorelin

To a tube containing 10  $\mu\text{l}$  of a  $3 \times 10^{-4}$  M aqueous solution of leuprorelin and 10  $\mu\text{l}$  of 0.01 mg/ml lactoperoxidase, 10  $\mu\text{l}$  (37 MBq) of a solution of  $\text{Na}^{125}\text{I}$  was added. After stirring, 10  $\mu\text{l}$  of 0.001%  $\text{H}_2\text{O}_2$  was added, and a reaction was carried out at room temperature for 20 minutes. By adding 700  $\mu\text{l}$  of a 0.05% TFA (trifluoroacetic acid) solution, the reaction was stopped, followed by purification by reversed-phase HPLC. The HPLC conditions used are shown below.  $^{125}\text{I}$ -leuprorelin was eluted at a retention time of 26 to 27 minutes.

Column: TSKgel ODS-80<sup>TM</sup> (TM indicates a registered trademark; the same applies below) CTR (4.6 mm x 10 cm)  
 Eluents: Solvent A (0.05% TFA)



Solvent B (40% CH<sub>3</sub>CN-0.05% TFA)

0 minute (100% Solvent A) - 3 minutes (100% Solvent A) - 7 minutes (50% Solvent A + 50% Solvent B) - 40 minutes (100% Solvent B)

- 5 Eluting temperature: Room temperature  
Elution rate: 1 ml/min

#### Experimental Example 2

- 10 Preparation of a rat pituitary anterior lobe membrane fraction containing GnRH receptors

- Anterior lobes of the pituitary glands were isolated from forty Wistar rats (8 weeks old, male), and washed with ice-cooled homogenate buffer [25 mM Tris (tris(hydroxymethyl)aminomethane)-HCl, 0.3 M sucrose, 1 mM EGTA (glycol-etherdiamine-N,N,N',N'-tetraacetic acid), 0.25 mM PMSF (phenylmethylsulfonyl fluoride), 10 U/ml aprotinin, 1 mg/ml pepstatin, 20 mg/ml leupeptin, 100 mg/ml phosphoramidon, 0.03% sodium azide, pH 7.5]. The pituitary tissue was floated in 2 ml of the homogenate buffer and homogenized using a Polytron homogenizer. The homogenate was centrifuged at 700 x g for 15 minutes. The supernatant was taken in an ultracentrifuge tube and centrifuged at 100,000 x g for 1 hour to provide a membrane fraction pellet. This pellet was suspended in 2 ml of assay buffer [25 mM Tris-HCl, 1 mM EDTA (ethylenediaminetetraacetic acid), 0.1% BSA (bovine serum albumin), 0.25 mM PMSF, 1 mg/ml pepstatin, 20 mg/ml leupeptin, 100 mg/ml phosphoramidon, 0.03% sodium azide, pH 7.5) and the suspension was centrifuged at 100,000 x g for 1 hour. The membrane fraction recovered as a pellet was resuspended in 10 ml of assay buffer, divided into portions, preserved at -80 °C and thawed when needed.

#### Experimental Example 3

- 35 Preparation of CHO (Chinese hamster ovarian) cell membrane fraction containing human GnRH receptor

Human GnRH receptor-expressing CHO cells (EP-A-678577) ( $10^9$  cells) were suspended in phosphate-buffered saline supplemented with 5 mM EDTA (ethylenediaminetetraacetic acid) (PBS-EDTA) and centrifuged at  $100 \times g$  for 5 minutes. To the cell pellet, 10 ml of a cell homogenate buffer (10 mM  $\text{NaHCO}_3$ , 5 mM EDTA, pH 7.5) was added, followed by homogenization using the Polytron homogenizer. After centrifugation at  $400 \times g$  for 15 minutes, the supernatant was transferred to an ultracentrifugation tube and centrifuged at  $100,000 \times g$  for 1 hour to yield a membrane fraction precipitate. This precipitate was suspended in 2 ml of an assay buffer and centrifuged at  $100,000 \times g$  for 1 hour. The membrane fraction recovered as a precipitate was again suspended in 20 ml of the assay buffer, dispensed, and stored at  $-80^\circ\text{C}$  before use upon thawing.

#### Experimental Example 4

##### Determination of $^{125}\text{I}$ -leuprorelin binding inhibition rate

The rat and human membrane fractions prepared in Experimental Examples 2 and 3 were diluted with the assay buffer to yield a 200 mg/ml dilution, which was then dispensed at 188  $\mu\text{l}$  per tube. Where the rat pituitary anterior lobe membrane fraction was used, to each tube, 2 ml of a solution of 0.1 mM compound in 60% DMSO (dimethyl sulfoxide) and 10  $\mu\text{l}$  of 38 nM  $^{125}\text{I}$ -leuprorelin were added simultaneously. Where the cell membrane fraction of the CHO with human GnRH receptors expressed, to each tube, 2 ml of a solution of 2 mM compound in 60% DMSO and 10  $\mu\text{l}$  of 38 nM  $^{125}\text{I}$ -leuprorelin were added simultaneously. To determine maximum binding quantity, a reaction mixture of 2  $\mu\text{l}$  of 60% DMSO and 10  $\mu\text{l}$  of 38 nM  $^{125}\text{I}$ -leuprorelin was prepared. To determine non-specific binding amount, a reaction mixture of 2  $\mu\text{l}$  of

100  $\mu$ M leuprorelin in solution in 60% DMSO and 10  $\mu$ l of 38 nM  $^{125}$ I-leuprorelin was prepared.

Where the rat or bovine pituitary anterior lobe membrane fraction was used, the reaction was conducted at 4 °C for 90 minutes. Where the membrane fraction of the CHO with human GnRH receptors expressed was used, the reaction was carried out at 25 °C for 60 minutes. After each reaction, the reaction mixture was aspirated and filtered through a polyethyleneimine-treated Whatman glass filter (GF-F). After this filtration, the radioactivity of  $^{125}$ I-leuprorelin remaining on the filter paper was measured with a  $\gamma$ -counter. The expression  $(TB-SB)/(TB-NSB) \times 100$  (where SB = radioactivity with the compound added, TB = maximum bound radioactivity, NSB = nonspecifically bound radioactivity) was calculated to find the binding inhibition rate (%) of each test compound. Furthermore, the inhibition rate was determined by varying the concentration of the test substance and the 50% inhibitory concentration ( $IC_{50}$  value) of the compound was calculated from Hill plot. The results are shown in below.

Test Compound	binding inhibition		$IC_{50}$ value	
	rate (%)		( $\mu$ M)	
	Rat (1 $\mu$ M)	Human (20 $\mu$ M)	Rat	Human
Compd. of Ex.1-2	96	102	0.06	0.0001
Compd. of Ex.3	62	NT	0.6	0.0002

NT: not measured

#### Experimental Example 5

Suppression of blood LH in castrated monkeys  
The compound produced in Example 1-2 was orally administered to castrated male cynomolgus monkeys (*Macaca fascicularis*), and blood LH was quantified. The male cynomolgus monkeys, used at 3 years 8 months to 7 years 7 months

of age at time of experimentation, had been castrated more than half a year prior to the examination. Test animals [n = 2; compound (1) and compound (2)] were given 30 mg/kg (3 ml/kg) of the compound suspended in 0.5% methyl cellulose at a final concentration of 1% by oral administration, and control animals [n = 3; control (1), control (2) and control (3)] were given 3 ml/kg of the 0.5% methyl cellulose dispersant alone by oral administration. At 24 hours and immediately before administration and at 2, 4, 6, 8, 24, and 48 hours after administration, blood was collected for heparinized plasma samples via the femoral vein and immediately stored under freezing conditions.

Plasma LH concentrations were determined by a bioassay using mouse testicular cells. The testicular cells were collected from male BALB/c mice (8 to 9 weeks of age) and washed three times with 1 ml of Dulbecco's modified Eagle medium (DMEM-H) containing 20 mM HEPES and 0.2% BSA per testis. After incubation at 37 °C for 1 hour, the cells were passed through a nylon mesh filter (70 µm) and dispensed to test tubes at  $8 \times 10^5$  cells/tube. After the cells were washed twice with 0.4 ml of DMEM-H, 0.4 ml of a DMEM-H solution containing either equine LH (Sigma Company), as the standard LH, or monkey plasma, previously diluted up to 1,000 fold, as the test sample, was added, followed by a reaction at 37 °C for 2 hours. The testosterone concentration in the culture supernatant was determined by a radioimmunoassay (CIS Diagnostics Company), and the LH concentration in the test monkey plasma was calculated from the standard curve for the standard equine LH.

The results are given together in Figure 1.

The compound indicated is the compound obtained in Example 1-2.

For the control (1), the control (2), and the control (3), changes over time in the LH concentrations in each animal are expressed as percent ratios to the respective reference

values, which comprise the LH concentrations immediately before administration in each control animal (cynomolgus monkey). Similarly, for the compound (1) and the compound (2), changes over time in the LH concentrations in each animal (cynomolgus monkey) receiving the compound of Example 1-2 are expressed as percent ratios to the respective reference values, which comprise the LH concentrations immediately before administration of the compound. The time of administration was defined as zero (0), and hours before and after administration shown by minus and plus, respectively.

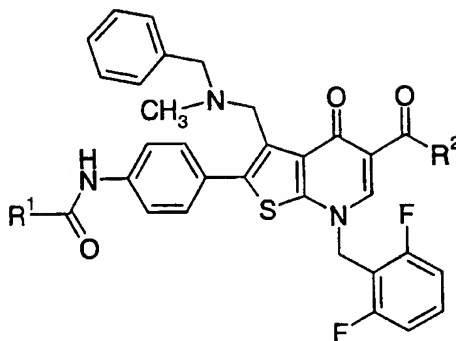
#### INDUSTRIAL APPLICABILITY

The compound of the present invention possesses excellent gonadotropin-releasing hormone antagonizing activity. It is also good in oral absorbability and excellent in stability and pharmacokinetics. With low toxicity, it is also excellent in safety.

The compound of the present invention can therefore be used as a prophylactic or therapeutic agent for hormone-dependent diseases etc. Specifically, it is effective as a prophylactic or therapeutic agent for sex hormone-dependent cancers (e.g., prostatic cancer, uterine cancer, breast cancer, pituitary tumor), prostatic hypertrophy, hysteromyoma, endometriosis, precocious puberty, amenorrhea syndrome, multilocular ovary syndrome, pimples etc, or as a pregnancy regulator (e.g., contraceptive), infertility remedy or menstruation regulator. It is also effective as an animal estrous regulator, food meat quality improving agent or animal growth regulator in the field of animal husbandry, and as a fish spawning promoter in the field of fishery.

## CLAIMS

1. A compound of the formula:



5

wherein R<sup>1</sup> represents a C<sub>1-7</sub> alkyl group which may be substituted, a C<sub>3-7</sub> cycloalkyl group which may be substituted, a C<sub>1-6</sub> alkoxyamino group which may be substituted or a hydroxyamino group which may be substituted;  
10 and  
R<sup>2</sup> represents a C<sub>1-7</sub> alkyl group which may be substituted or a phenyl group which may be substituted;  
when R<sup>1</sup> is an unsubstituted C<sub>1-7</sub> alkyl group, then R<sup>2</sup> is a substituted C<sub>1-7</sub> alkyl group or a substituted phenyl group,  
15 or a salt thereof.

2. A compound of Claim 1 or a salt thereof, wherein  
R<sup>1</sup> is (1) a C<sub>1-7</sub> alkyl group which may be substituted by 1 to 5 substituents selected from the group consisting of  
20 (i) hydroxy, (ii) C<sub>1-7</sub> acyloxy, (iii) amino which may be substituted by 1 or 2 substituents selected from the group consisting of C<sub>1-6</sub> alkoxy-carbonyl, benzyloxycarbonyl, C<sub>1-3</sub> acyl, C<sub>1-3</sub> alkylsulfonyl and C<sub>1-3</sub> alkyl, (iv) C<sub>1-10</sub> alkoxy which may be substituted by 1 to 3 substituents selected from  
25 the group consisting of C<sub>3-7</sub> cycloalkyloxy-carbonyl and C<sub>1-3</sub>

alkoxy and (v) C<sub>1-6</sub> alkoxy-carbonyl,

- (2) a C<sub>3-7</sub> cycloalkyl group which may be substituted by 1 to 3 substituents selected from the group consisting of (i) hydroxy, (ii) C<sub>1-7</sub> acyloxy, (iii) amino which may be substituted by 1 or 2 substituents selected from the group consisting of C<sub>1-6</sub> alkoxy-carbonyl, benzyloxycarbonyl, C<sub>1-3</sub> acyl, C<sub>1-3</sub> alkylsulfonyl and C<sub>1-3</sub> alkyl, (iv) C<sub>1-10</sub> alkoxy which may be substituted by 1 to 3 substituents selected from the group consisting of C<sub>3-7</sub> cycloalkyloxy-carbonyl and C<sub>1-3</sub> alkoxy and (v) C<sub>1-6</sub> alkoxy-carbonyl,
- (3) a C<sub>1-6</sub> alkoxyamino group which may be substituted by 1 to 5 substituents selected from the group consisting of (i) hydroxy, (ii) C<sub>1-7</sub> acyloxy, (iii) amino which may be substituted by 1 or 2 substituents selected from the group consisting of C<sub>1-6</sub> alkoxy-carbonyl, benzyloxycarbonyl, C<sub>1-3</sub> acyl, C<sub>1-3</sub> alkylsulfonyl and C<sub>1-3</sub> alkyl, (iv) C<sub>1-10</sub> alkoxy which may be substituted by 1 to 3 substituents selected from the group consisting of C<sub>3-7</sub> cycloalkyloxy-carbonyl and C<sub>1-3</sub> alkoxy and (v) C<sub>1-6</sub> alkoxy-carbonyl, or
- (4) a hydroxyamino group which may be substituted by 1 or 2 substituents selected from the group consisting of (i) C<sub>1-7</sub> acyloxy, (ii) amino which may be substituted by 1 or 2 substituents selected from the group consisting of C<sub>1-6</sub> alkoxy-carbonyl, benzyloxycarbonyl, C<sub>1-3</sub> acyl, C<sub>1-3</sub> alkylsulfonyl and C<sub>1-3</sub> alkyl, (iii) C<sub>1-10</sub> alkoxy which may be substituted by 1 to 3 substituents selected from the group consisting of C<sub>3-7</sub> cycloalkyloxy-carbonyl and C<sub>1-3</sub> alkoxy and (iv) C<sub>1-6</sub> alkyl; and

R<sup>2</sup> is (1) a C<sub>1-7</sub> alkyl group which may be substituted by 1 to 5 substituents selected from the group consisting of (i) hydroxy, (ii) C<sub>1-7</sub> acyloxy, (iii) amino which may be

substituted by 1 or 2 substituents selected from the group consisting of C<sub>1-6</sub> alkoxy-carbonyl, benzyloxycarbonyl, C<sub>1-3</sub> acyl, C<sub>1-3</sub> alkylsulfonyl and C<sub>1-3</sub> alkyl, (iv) C<sub>1-10</sub> alkoxy which may be substituted by 1 to 3 substituents selected from the group consisting of C<sub>3-7</sub> cycloalkyloxy-carbonyl and C<sub>1-3</sub> alkoxy and (v) C<sub>1-6</sub> alkoxy-carbonyl, or

(2) a phenyl group which may be substituted by 1 to 5 substituents selected from the group consisting of halogen, C<sub>1-3</sub> alkyl and C<sub>1-3</sub> alkoxy.

10        3. A compound of Claim 1 or a salt thereof, wherein R<sup>1</sup> is a C<sub>1-7</sub> alkyl group which may be substituted or a C<sub>3-7</sub> cycloalkyl group which may be substituted.

4. A compound of Claim 1 or a salt thereof, wherein R<sup>1</sup> is a substituted branched C<sub>3-7</sub> alkyl group or a substituted C<sub>3-7</sub> cycloalkyl group.

5. A compound of Claim 1 or a salt thereof, wherein R<sup>1</sup> is a C<sub>1-7</sub> alkyl group substituted by hydroxy or a C<sub>3-7</sub> cycloalkyl group substituted by hydroxy.

6. A compound of Claim 1 or a salt thereof, wherein R<sup>1</sup> is a substituted C<sub>3-7</sub> cycloalkyl group.

7. A compound of Claim 1 or a salt thereof, wherein R<sup>1</sup> is a cyclopropyl group which may be substituted by hydroxy.

8. A compound of Claim 1 or a salt thereof, wherein R<sup>2</sup> is a branched C<sub>3-7</sub> alkyl group which may be substituted.

9. A compound of Claim 1 or a salt thereof, wherein R<sup>2</sup> is a phenyl group which may be substituted.

10. A compound of Claim 1 or a salt thereof, wherein R<sup>2</sup> is a phenyl group.

11. A compound of Claim 1 or a salt thereof, wherein R<sup>1</sup> is a C<sub>3-7</sub> cycloalkyl group and R<sup>2</sup> is a C<sub>1-6</sub> alkyl group.

12. A compound of Claim 1 or a salt thereof, wherein



R<sup>1</sup> is (1) a C<sub>1-4</sub> alkyl group substituted by 1 or 2 hydroxy, (2) a C<sub>3-7</sub> cycloalkyl group substituted by hydroxy, or (3) a C<sub>1-3</sub> alkoxyamino group; and

R<sup>2</sup> is an isopropyl group or a phenyl group.

5           13. A compound of Claim 1 or a salt thereof, wherein  
R<sup>1</sup> is (1) a C<sub>1-7</sub> alkyl group which may be substituted by 1 or 2 substituents selected from the group consisting of hydroxy, C<sub>1-3</sub> alkyl-carbonyloxy, amino, benzyloxycarbonylamino, C<sub>1-3</sub> alkoxy, C<sub>1-3</sub> alkoxy-C<sub>1-3</sub> alkoxy and C<sub>1-3</sub> alkoxy-carbonyl, (2) a C<sub>3-7</sub> cycloalkyl group which  
10           may be substituted by a hydroxy or a C<sub>1-3</sub> alkyl-carbonyloxy, or (3) a C<sub>1-3</sub> alkoxyamino group; and

R<sup>2</sup> is (1) an isopropyl group which may be substituted by a hydroxy or (2) a phenyl group.

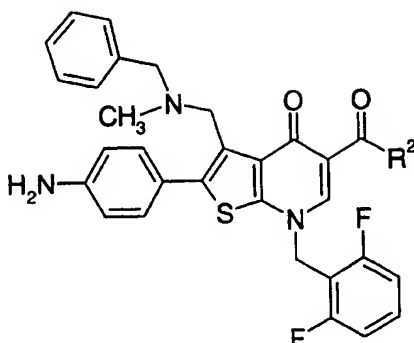
15           14. 3-(N-Benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-(4-cyclopropanecarbonylamino)phenyl)-4-oxothieno[2,3-b]pyridine or a salt thereof.

            15. 3-(N-Benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-[4-(3-hydroxy-2-methylpropionylamino)phenyl]-4-oxothieno[2,3-b]pyridine  
20           or a salt thereof.

            16. 3-(N-Benzyl-N-methylaminomethyl)-4,7-dihydro-5-isobutyryl-7-(2,6-difluorobenzyl)-2-[4-[(1-hydroxycyclopropyl)carbonylamino]phenyl]-4-oxothieno[2,3-b]pyridine or a salt thereof.  
25           

            17. 3-(N-Benzyl-N-methylaminomethyl)-5-benzoyl-7-(2,6-difluorobenzyl)-4,7-dihydro-2-[4-[(1-hydroxycyclopropyl)carbonylamino]phenyl]-4-oxothieno[2,3-b]pyridine or a salt thereof.  
30           

            18. A process for producing a compound of Claim 1 or a salt thereof, which comprises reacting a compound of the formula:



wherein  $R^2$  represents a  $C_{1-7}$  alkyl group which may be  
 5 substituted or a phenyl group which may be substituted, or  
 a salt thereof, with

i) a compound of the formula:



wherein  $R^{1a}$  represents a  $C_{1-7}$  alkyl group which may be  
 10 substituted or a  $C_{3-7}$  cycloalkyl group which may be  
 substituted, or a salt thereof or a reactive derivative  
 thereof; or

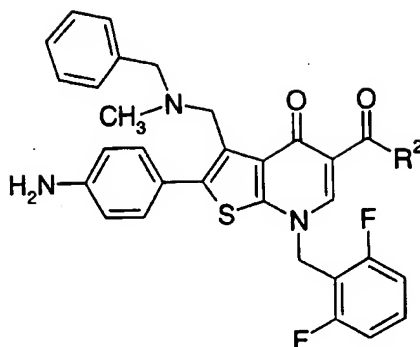
ii) carbonyldiimidazole, phosgene or a chloroformate,  
 followed by reacting with a compound of the formula:



15 wherein  $R^{1b}$  represents a  $C_{1-6}$  alkoxyamino group which may be  
 substituted or a hydroxyamino group which may be substituted,  
 or a salt thereof.

19. A process for producing a compound of Claim 3 or  
 20 a salt thereof, which comprises reacting a compound of the  
 formula:

105



wherein  $R^2$  represents a  $C_{1-7}$  alkyl group which may be substituted or a phenyl group which may be substituted, or  
 5 a salt thereof, with a compound of the formula:



wherein  $R^{1a}$  represents a  $C_{1-7}$  alkyl group which may be substituted or a  $C_{3-7}$  cycloalkyl group which may be substituted, or a salt thereof or a reactive derivative  
 10 thereof.

20. A pharmaceutical composition which comprises a compound of Claim 1 or a salt thereof.

21. A pharmaceutical composition of Claim 20 which is for antagonizing gonadotropin-releasing hormone.

15 22. A pharmaceutical composition of claim 21 which is for preventing or treating a sex hormone dependent disease.

23. A method for antagonizing gonadotropin-releasing hormone in a mammal in need thereof which comprises administering to said mammal an effective amount of a compound  
 20 of Claim 1 or a salt thereof with a pharmaceutically acceptable excipient, carrier or diluent.

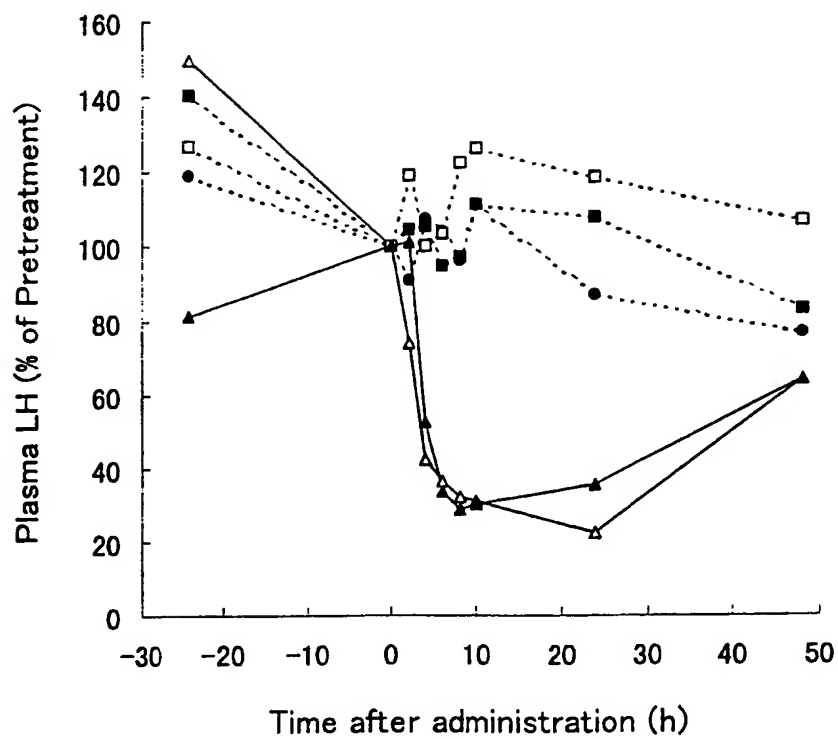
24. Use of a compound of Claim 1 or a salt thereof for manufacturing a pharmaceutical composition for antagonizing gonadotropin-releasing hormone.

25

1/1

Drawing

Fig. 1



---■--- control (1)

---◆--- control (2)

---□--- control (3)

-△- compound (1)

-▲- compound (2)

# INTERNATIONAL SEARCH REPORT

Int. .onal Application No

PCT/JP 99/03379

## A. CLASSIFICATION OF SUBJECT MATTER

IPC 6 C07D495/04 A61K31/435 //(C07D495/04,333:00,221:00)

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 6 C07D A61K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 0 781 774 A (TAKEDA CHEMICAL INDUSTRIES LTD) 2 July 1997 (1997-07-02) abstract; claims page 108, line 45 - line 48 page 110; example 3.20.19; table 29 ---	1,20,23, 24
X	WO 97 41126 A (HAYASE YOJI ;IMADA TAKASHI (JP); FURUYA SHUICHI (JP); SUZUKI NOBUH) 6 November 1997 (1997-11-06) cited in the application abstract; claims page 41 -page 58; examples claim 6 -----	1,20,23, 24



Further documents are listed in the continuation of box C.



Patent family members are listed in annex.

### \* Special categories of cited documents :

- \*A\* document defining the general state of the art which is not considered to be of particular relevance
- \*E\* earlier document but published on or after the international filing date
- \*L\* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- \*O\* document referring to an oral disclosure, use, exhibition or other means
- \*P\* document published prior to the international filing date but later than the priority date claimed

\*T\* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

\*X\* document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

\*Y\* document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

\*Z\* document member of the same patent family

Date of the actual completion of the international search

1 December 1999

Date of mailing of the international search report

13/12/1999

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2  
NL - 2280 HV Rijswijk  
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,  
Fax: (+31-70) 340-3016

Authorized officer

Paisdor, B

# INTERNATIONAL SEARCH REPORT

International application No.

PCT/JP 99/03379

## Box I Observations where certain claims were found unsearchable (Continuation of item 1 of first sheet)

This International Search Report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☒ Claims Nos.: 23  
because they relate to subject matter not required to be searched by this Authority, namely:  
Remark: Although claim 23  
is directed to a method of treatment of the human/animal  
body, the search has been carried out and based on the alleged  
effects of the compound/composition.
2. ☐ Claims Nos.:  
because they relate to parts of the International Application that do not comply with the prescribed requirements to such  
an extent that no meaningful International Search can be carried out, specifically:
3. ☐ Claims Nos.:  
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

## Box II Observations where unity of invention is lacking (Continuation of item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this International Search Report covers all  
searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment  
of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this International Search Report  
covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this International Search Report is  
restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

☐ The additional search fees were accompanied by the applicant's protest.

☐ No protest accompanied the payment of additional search fees.

# INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/JP 99/03379

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
EP 0781774 A	02-07-1997	CA 2192283 A	09-06-1997
		JP 9216823 A	19-08-1997
		US 5977132 A	02-11-1999
WO 9741126 A	06-11-1997	AU 2406597 A	19-11-1997
		CA 2250895 A	06-11-1997
		EP 0900222 A	10-03-1999
		JP 10036373 A	10-02-1998

**THIS PAGE BLANK (ISPTN)**